TF 400V / 600V

TRAY-MATIC®

Parts Illustrations

Note: This parts illustrations section contains standard assemblies and may not accurately represent your specific machine. Parts illustrations specific to your machine will be completed and mailed to you separately.

Proud manufacturers of the following packaging machinery lines:
SWF Machinery • Dyna-Pak • McDowell • Padlocker • Salwasser • Tri-Sterling • Yakima Wire
1949 E Manning Ave • Reedley, CA 93654 • Tel. (559) 638-8484 • Fax. (559) 638-7478 • Toll Free (800) 344-8951
Web: www.swfcompanies.com

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Thank you for choosing packaging equipment from SWF Companies.

The equipment you purchased will provide years of productive service, producing a high return on your investment. Your equipment was thoroughly tested for proper operation prior to shipment.

Before unpacking and installing your new equipment, please read this manual. It is your guide to safe installation, productive operation, and effective maintenance. We recommend you keep this manual available for future reference.

Be aware that our commitment to you does not end with your purchase. That is just the beginning. The safe and efficient operation of your SWF equipment is very important to us as a machine manufacturer.

Training and parts distribution are an integral part of our business. SWF service technicians have spent months of in-plant hands-on training, prior to servicing our worldwide installations. Their expertise on our equipment is as close as your telephone. Given sufficient notice, service technicians are available for dispatch to your installation. We also maintain an extensive inventory of spare parts. We typically can have the parts you need in your plant the next working day.

The entire family of SWF Companies, a Dover Diversified Company is committed to the success of your operation and thanks you again. Feel free to call us anytime.

SWF Companies is committed to providing product manuals that meet the needs of its valued customers. We invite you to offer suggestions for continued improvement of this manual.

To contact SWF Companies, Inc. Parts and Service	Published by:
Local ..... (559) 638-8484 Toll-Free..... (800) 344-8951 Fax ..... (559) 638-7478	SWF Companies, Inc. 1949 E Manning Ave Reedley, CA 93654 2003

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Introduction

The traymatic machines may be referred to by two different machine notations.

New Designation	Old Designation
TF 400V Traymatic	1T4 Traymatic
TF 600V Traymatic	1T6 Traymatic

The following terms are interchangeable:

- Traymatic, Former, Case Former, Tray Former, and Machine
- Carton, Box, Tray, Case, Blank
- Glue, Adhesive, Bonding Material

Safety

Machinery is hazardous when safety precautions are not followed. Follow these safety rules and practices for safe operation of the machinery and to prevent accidents. All operators and maintenance personnel working on or near SWF Companies machinery should be informed and supervised regarding safe machine operation.

All equipment manufactured by SWF Companies is safety tested prior to shipment. Records of machine safety tests are filed at the plant. Safety equipment on SWF machines is also tested in the customer's plant when a SWF Service Representative assists in starting up new equipment.

Verify all supervisors read and understand the entire contents of the operation portion of this manual, with particular attention to safety precautions. Anyone who works on or around the machine should read and understand the safety precautions noted throughout this manual.

- The responsibility for safe machine operation is shared among the employer, supervisor, operator, attendant, and all maintenance personnel working with the machine. Read the instructions. Re-read them periodically.
- Accident prevention should be continually evaluated. This means ALL potential hazards must be identified, and either eliminated or safeguarded. Along with creating safe conditions, employees should follow all safety procedures.
- If any questions arise regarding the safe operation or maintenance of this machine, immediately contact the service department of:

SWF Companies
1949 E. Manning Ave.
P.O. Box 548
Reedley, CA 93654-0548

Phone: 559-638-8484
Fax: 559-638-7478

Equipment Safety

SWF machinery uses safety devices to prevent injury to personnel coming into contact with the machine. Check all safety switches and devices daily to ensure they operate properly. Any removal or alteration of these devices results in serious injury.

Device	Description
	Guarding includes sheet metal fixed guards or transparent polycarbonate plastic. Hinged or sliding guard doors are installed in areas requiring easy access. Doors with safety interlocks automatically stop the machine by disconnecting the electrical power and dropping air from the machine when the door opens. The electrical power and air pressure remain off until all guard doors are closed and the start-up sequence is followed.
	Emergency Stop, or E-Stop is a lighted push/pull button installed on each operator control panel. The pulled-out (on) position allows for operation. The pushed-in (off) position of any e-stop button causes a complete machine shut-down by shutting off power and air to the machine. The dump valve releases air pressure, causing the air pressure switch to open and shut off the master control relay. The machine remains shut down until all emergency stop buttons are reset and the start-up sequence is performed. WARNING: Do not use the e-stops to prevent inadvertent starting of the machine. Always perform power and air lock out procedures on the main disconnect or designated auxiliary disconnect before reaching into the machine.
	The **DISCONNECT SWITCH or CIRCUIT BREAKER** mounts on the main electrical cabinet and shuts off electrical power to the machine. There may be additional remote disconnect switches mounted elsewhere on the machine. To open the electrical cabinet door, first move the disconnect switch to the **off** position. WARNING: Always use the lockout feature of the disconnect switch to ensure the electrical power remains off during any maintenance or repair work. Not all disconnect switches shut off all power. Some switches only shut-off power to a particular area or to certain components. Never assume any single disconnect switch shuts-off ALL power to the machine. Refer to the electrical schematics for specific information.

Precautions and Warnings

1. Always closely observe all DANGER, WARNING and CAUTION signs.
2. Machinery should never be operated or serviced by personnel taking any type of drug or sedative, under the influence of alcohol, or who is experiencing excessive fatigue.
3. Before starting any machinery, confirm all personnel and materials are clear of the machine.
4. Alert all personnel involved with the machine of any automatic cycling features.
5. Do not perform any maintenance or repair work without completing the following:
    a. Turn off electrical power at the main control panel.
    b. Use a padlock or other lock-out device to ensure the power stays off.
    c. Turn off the air supply.
    d. Use a padlock or other lock-out device to ensure the air stays off.

e. **NOTE:** Always follow ALL Start-up/Shut-down Procedures.

6. **NEVER** reach into or near any moving parts to clear a jam.
7. **NEVER** wear loose clothing or jewelry around moving parts.
8. **NEVER** place fingers near any "nip" point between driving pulleys, gears, belts, or sprockets while the machine is in operation. Take particular care around open areas such as conveyor drive chains, take-up pulleys, overhead ram shafts, case chairs and any carriages.
9. Always wear protective equipment such as safety glasses, hard hats, and hearing protection where required.
10. Keep the areas around transfer carriages, cylinders, case chairs, vacuum cap bars, and other moving parts free of obstructions.
11. Keep all floors around the machine free of obstructions and liquids. All personnel using water nearby should wear non-slip shoes.
12. Always use SWF recommended replacement parts to prevent injury and machine damage. Consult with SWF regarding possible equivalent substitutions prior to replacing any parts.
13. Wear safety glasses, safety gloves, and protective clothing to prevent injury from hot applicator parts, splashed hot melt adhesive material, and hot gun services.

ELECTRICAL: Always turn off and lock-out the main power disconnect on the electrical cabinet before proceeding with any electrical repairs. When the power must remain on to perform certain tests, use the following guidelines:

- Know what voltages are present before beginning any electrical work.
- NEVER allow any part of your body to touch the machine while testing voltages.
- NEVER work on a wet floor, a steel floor or other conductive surface. Cement is conductive due its ability to retain moisture. When working on a cement floor, stand on a rubber mat, plywood, or other non-conductive material.

DANGER: LOCK-OUT ALL POWER AND AIR BEFORE CLEARING ANY JAM.

After de-energizing the machine, carefully remove product to prevent personal injury or damage to the machine.

GLUE OPERATIONS: Wear safety glasses, safety gloves, and protective clothing to prevent injury from hot applicator parts, splashed hot melt adhesive material, and hot gun services.

Power Disconnect Switch

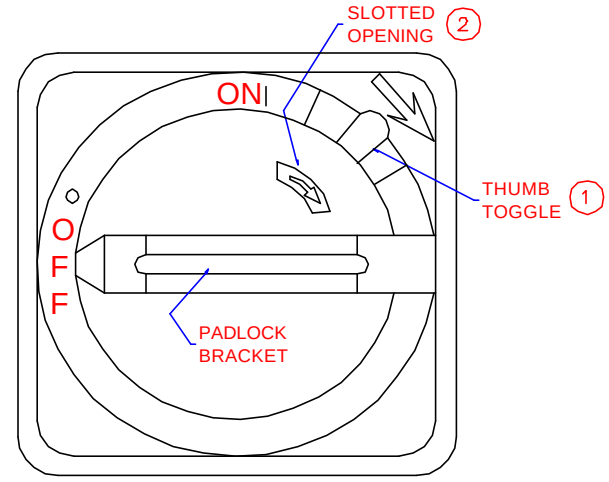
This switch must be in the ON position to operate the machine. Turn OFF when washing the machine or when making repairs or adjustments other than changeovers.

To open the control panel:

1. Twist the disconnect switch to the OFF position
2. Push down on the thumb switch (see figure 4, item 1) and slide the outer ring down
3. Pull open the door.

The power disconnect switch may be locked in the OFF position. To lockout the power, pull the black plastic bracket out from the handle and hook a padlock into the opening (in the off position only).

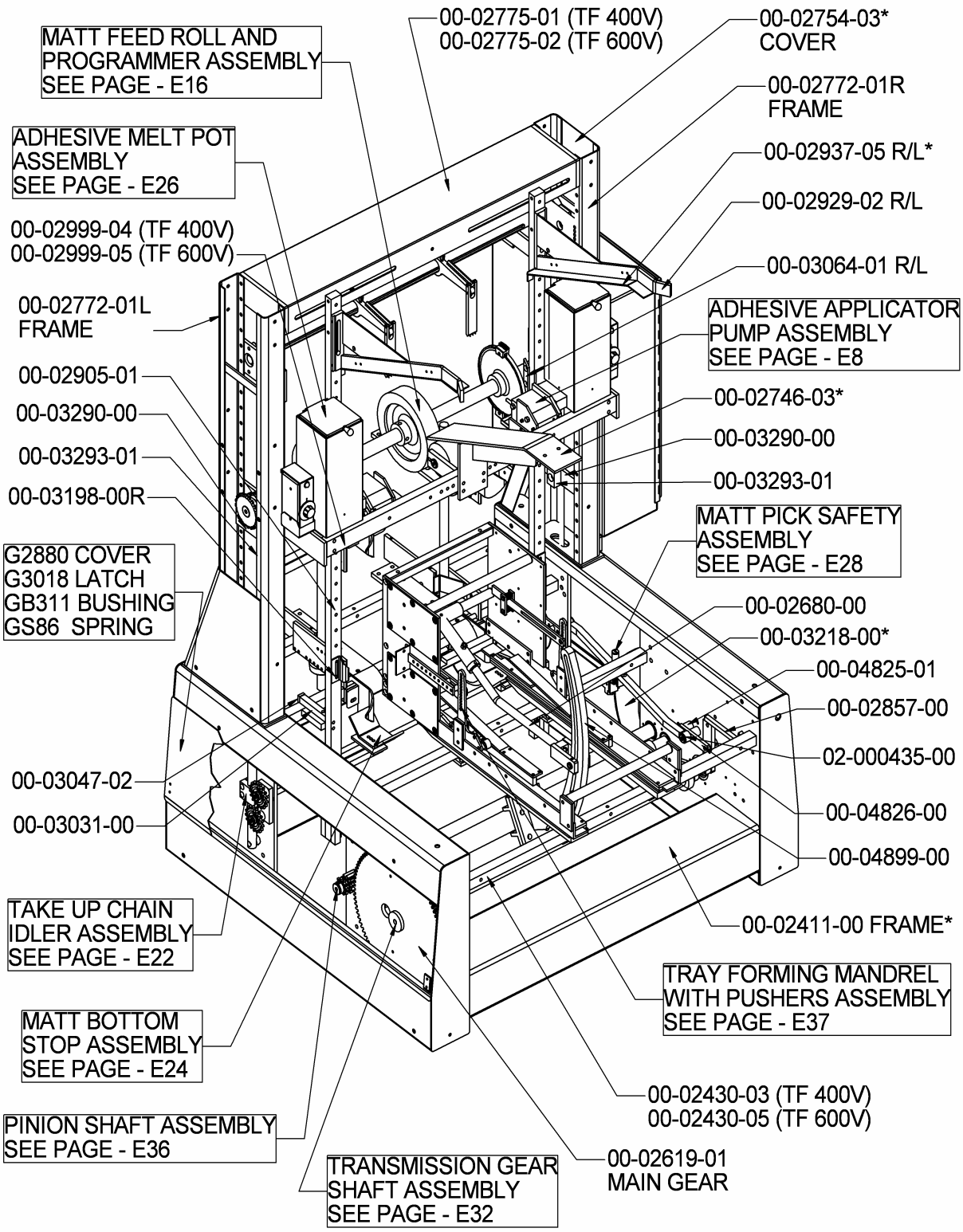
This prevents the power from being restored to the machine. For further instructions, refer to the documentation for the power lockout switch.

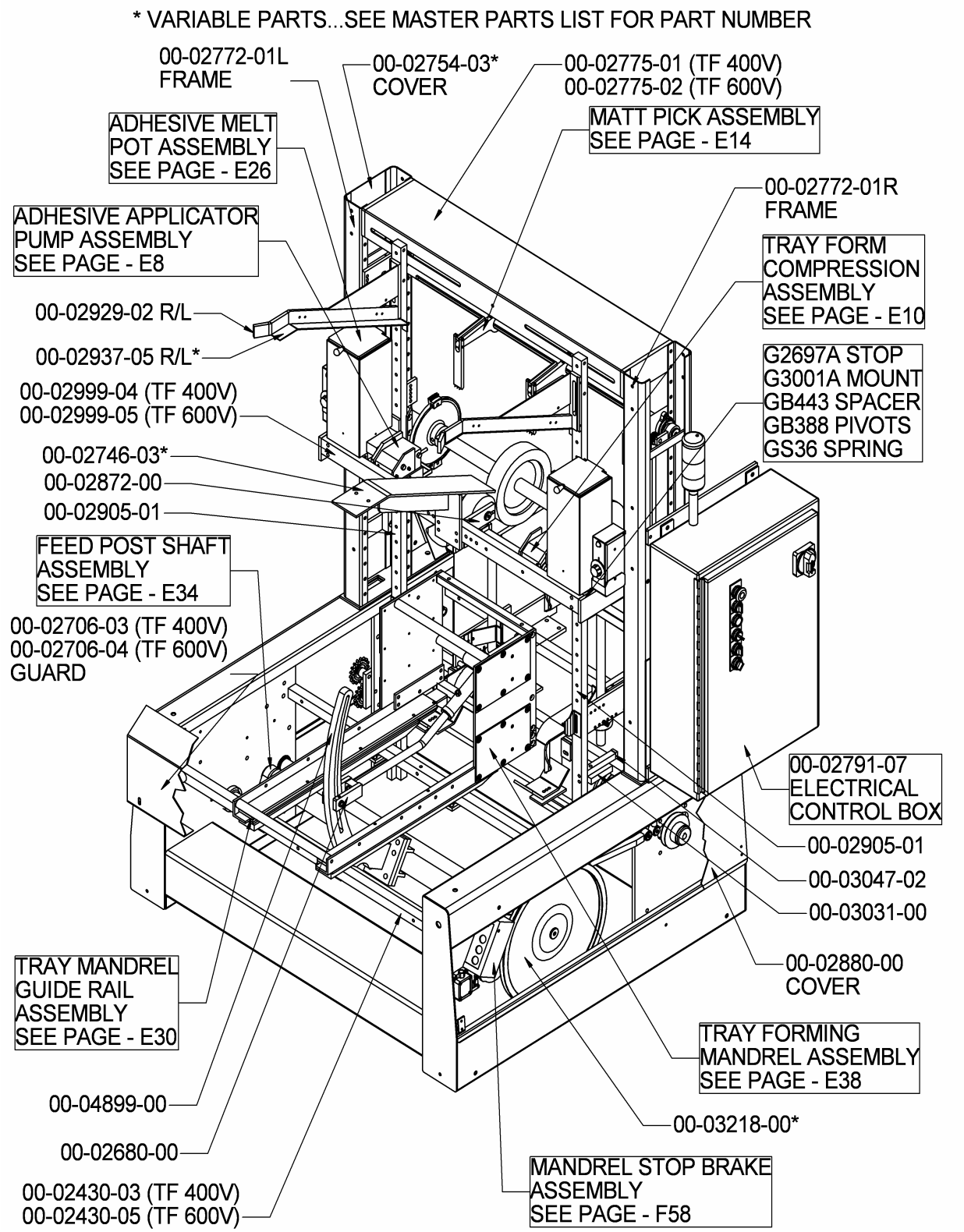


Additional Safety Notes

- Examine the frame and machine surfaces for abraded surfaces and sharp edges. File any sharp edges or surfaces smooth and cushion them against collision if the machine is near employee traffic patterns.
- Turn the main power switch to the "OFF" position before removing any guards at a drive or nip point.
- All guards and safety devices (interlocks) as manufactured and installed at the factory must be reinstalled after maintenance and before machine start-up.
- Maintenance personnel should always use protective measures to avoid contact with hot surfaces, resins, glue, or wax during clean up or repair of the adhesive system.
- The adhesive melt pots are provided with a temperature regulator. Turn the machine main electrical disconnect off at the end of each workday.
- Guards mounted at the factory protect the operator from drive units, nip points, and contact with electrical circuitry.
- All guards for the lower transmission, feed post, and program feed wheel must be securely in place before operating the machine.
- All guarding must always be in place while operating. Take extreme caution while making adjustments or size changes with the guards removed.

* VARIABLE PARTS...SEE MASTER PARTS LIST FOR PART NUMBER




* VARIABLE PARTS...SEE MASTER PARTS LIST FOR PART NUMBER
00-02772-01L FRAME
00-02754-03* COVER
00-02775-01 (TF 400V)
00-02775-02 (TF 600V)
MATT PICK ASSEMBLY SEE PAGE - E14
ADHESIVE MELT POT ASSEMBLY SEE PAGE - E26
00-02772-01R FRAME
ADHESIVE APPLICATOR PUMP ASSEMBLY SEE PAGE - E8
TRAY FORM COMPRESSION ASSEMBLY SEE PAGE - E10
00-02929-02 R/L
00-02937-05 R/L*
G2697A STOP
G3001A MOUNT
GB443 SPACER
GB388 PIVOTS
GS36 SPRING
00-02999-04 (TF 400V)
00-02999-05 (TF 600V)
00-02746-03*
00-02872-00
00-02905-01
FEED POST SHAFT ASSEMBLY SEE PAGE - E34
00-02706-03 (TF 400V)
00-02706-04 (TF 600V)
GUARD
00-02791-07 ELECTRICAL CONTROL BOX
00-02905-01
00-03047-02
00-03031-00
00-02880-00 COVER
TRAY MANDREL GUIDE RAIL ASSEMBLY SEE PAGE - E30
TRAY FORMING MANDREL ASSEMBLY SEE PAGE - E38
00-04899-00
00-03218-00*
00-02680-00
MANDREL STOP BRAKE ASSEMBLY SEE PAGE - F58
00-02430-03 (TF 400V)
00-02430-05 (TF 600V)

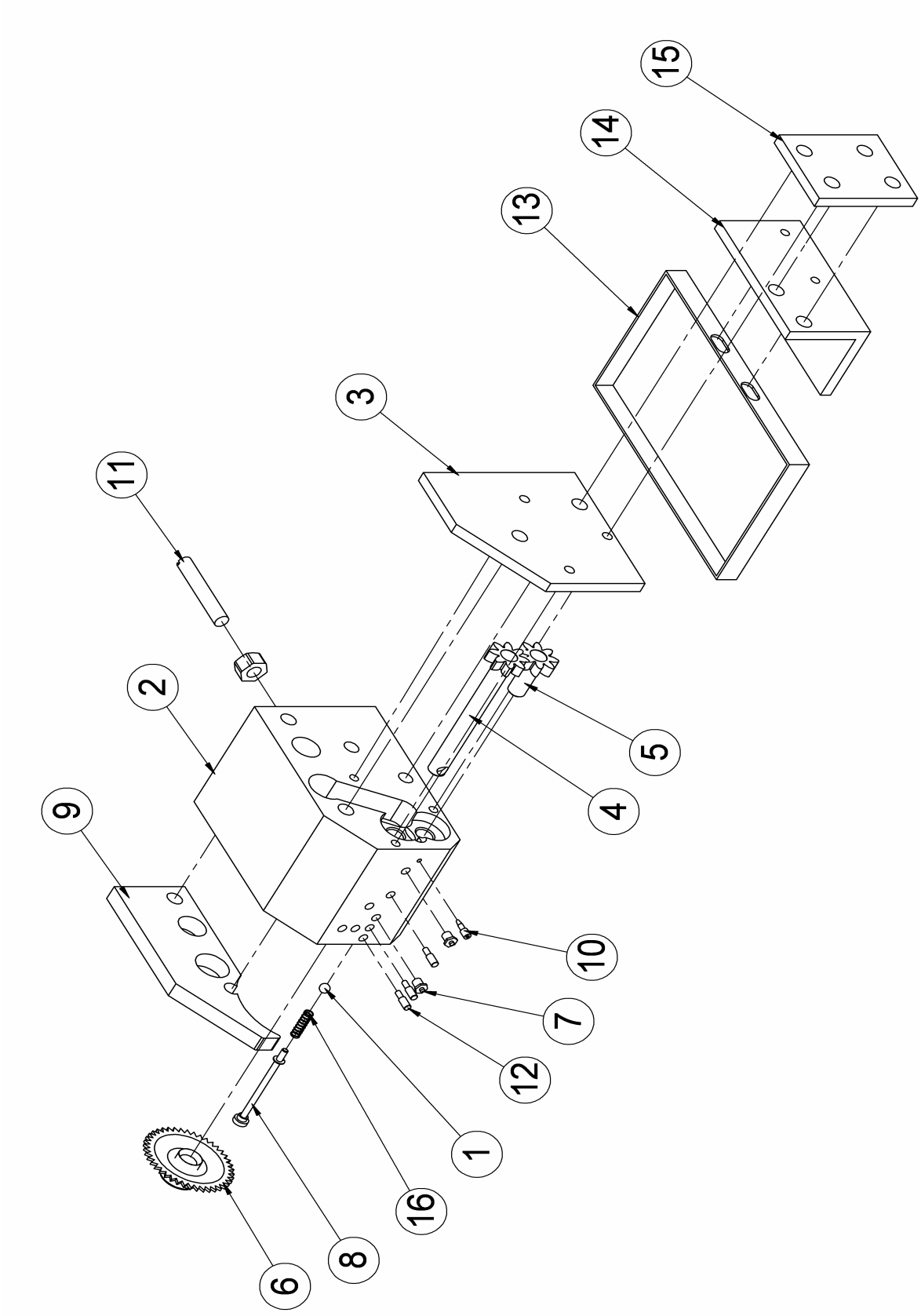
Parts Illustrations

Adhesive Applicator Pump Assembly

Item	Qty.	Part No.	Description
1 *	1	00-00967-05	7/32 DIA. BALL, ADHESIVE APPLICATOR CHECK VALVE
2 *	1R / 1L	00-03143-02	HOUSING, ADHESIVE APPLICATOR PUMP
3 *	1R / 1L	00-03144-00	PLATE, ADHESIVE APPLICATOR HOUSING
4 *	1	00-03145-02	GEAR, ADHESIVE PUMP DRIVE
5 *	1	00-03146-01	GEAR, ADHESIVE PUMP IDLE
6 *	1	00-03147-00	WHEEL, ADHESIVE PUMP DRIVE
7 *	2	00-03148-00	JET, ADHESIVE APPLICATOR
8 *	1	00-03149-02	PLUG, ADHESIVE APPLICATOR CHECK VALVE SPRING
9 *	1	00-03151-04	SPACER, ADHESIVE APPLICATOR PUMP HOUSING
10*	1	00-03153-00	NEEDLE VALVE, ADHESIVE APPLICATOR VOLUME CONTROL
11*	1	00-03477-00	STUD, ADHESIVE APPLICATOR SUPPORT
12*	3	00-03665-00	SCREW, ADHESIVE APPLICATOR JET HOLE PLUG
13	1	00-08232-00	PAN, ADHESIVE APPLICATOR DRIP (STANDARD)
	1	00-08232-01	PAN, ADHESIVE APPLICATOR DRIP
			(W / AUXILIARY & 1" PUMP TO AUXILIARY SPACERS)
	1	00-08232-02	PAN, ADHESIVE APPLICATOR DRIP (W / AUXILIARY ONLY)
	1	00-08232-03	PAN, ADHESIVE APPLICATOR DRIP
			(W / AUXILIARY & 2 1/2" PUMP TO AUXILIARY SPACERS)
14	1R / 1L	00-08233-00	ANGLE, DRIP PAN MOUNTING
15	1	00-08424-00	EXTENSION, ADHESIVE PUMP DRIP PAN
16*	1	19-00152-00	SPRING, ADHESIVE APPLICATOR CHECK VALVE

Note: These parts may be purchased as a preassembled package.
To order, specify #60-00160-03, right or left.

* *These parts included in package #60-00160-03.*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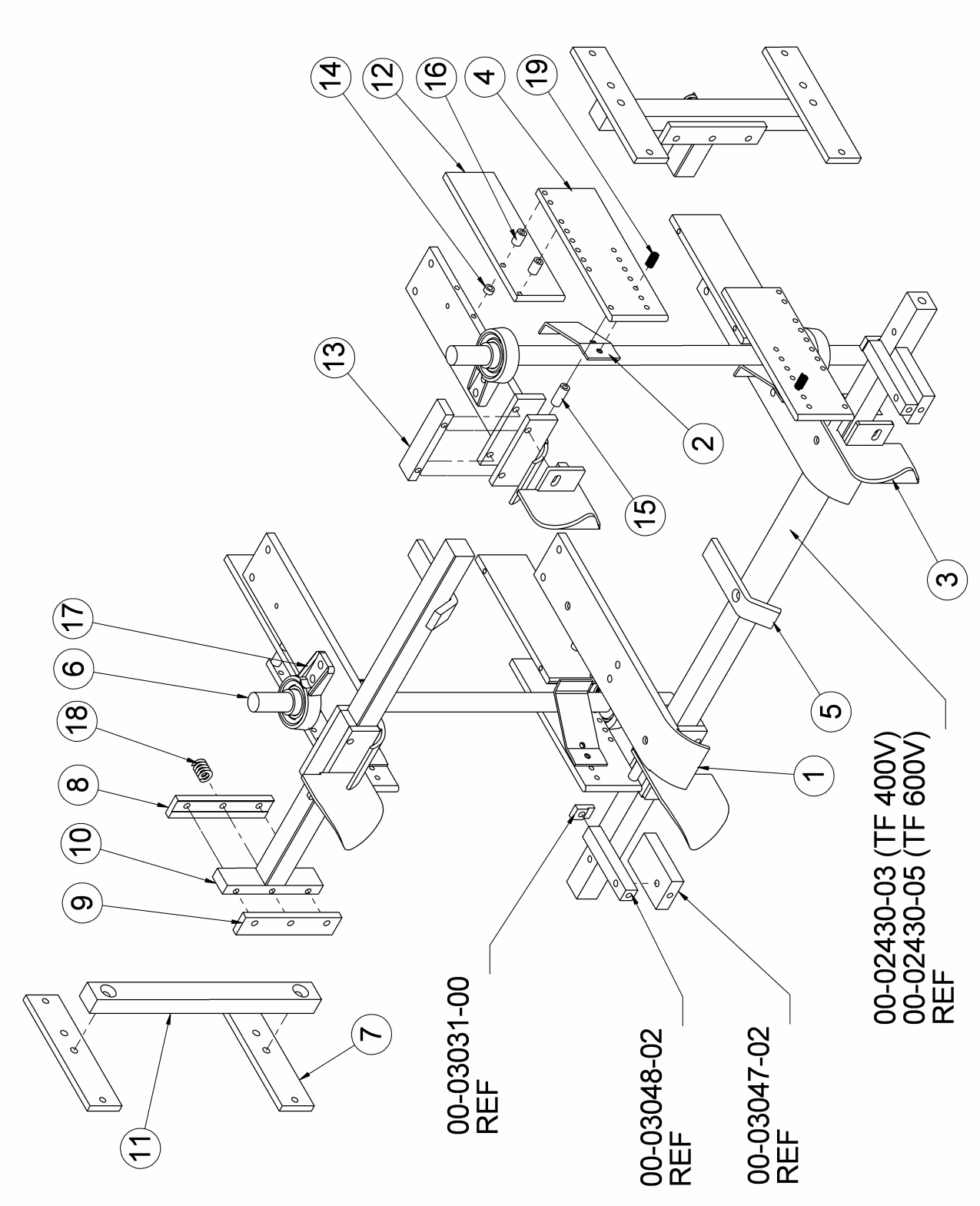
Tray Form Compression Assembly

Item	Qty.	Part No.	Description
1	2R / 2L	00-02785-01	SHOE, TRAY FORMING
2	4	00-02879-01	PAWL, TRAY STRIPPER
3	2R / 2L	00-02927-02	PLOW, INNER FLAP FORMING
4	4	00-02933-03	SHOE, TRAY FORMING SIDE
5	2	00-03054-01	SHOE, CENTER TRAY FORMING
6	2	00-03057-05	ROD, TRAY FORM COMPRESSION (MADE TO ORDER)
7	4	00-03290-00	BRACKET, FORMING SHOE, MOUNTING SIDE BAR
8	2	00-03291-00	PLATE, UPPER TRAY FORM SHOE MTG. BAR CLAMP
9	2	00-03291-01	PLATE, UPPER TRAY FORM SHOE MTG. BAR FIXED
10	1	00-03292-00	BAR, UPPER TRAY FORM SHOE MTG. (TF 400V)
	1	00-03292-01	BAR, UPPER TRAY FORM SHOE MTG. (TF 600V)
11	2	00-03293-01	BAR, FORMING SHOE MOUNTING SIDE
12	4	00-03514-04	PLATE, TRAY COMPRESSION EXTENSION
13	4	00-03566-00	BAR, FORMING SHOE CLAMP
14	4	02-00053-00	SPACER, TRAY COMPRESSION PLATE
15	4	02-00474-00	SPACER, TRAY FORMING SIDE SHOE
16	8	02-00475-00	SPACER, TRAY FORMING SIDE SHOE
17	4	05-00065-01	BEARING, COMPRESSION ROD
18	2	19-00054-00	SPRING, MOUNT BAR CLAMP
19	4	19-00108-00	SPRING, STRIPPER PAWL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00-03031-00
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00-03048-02
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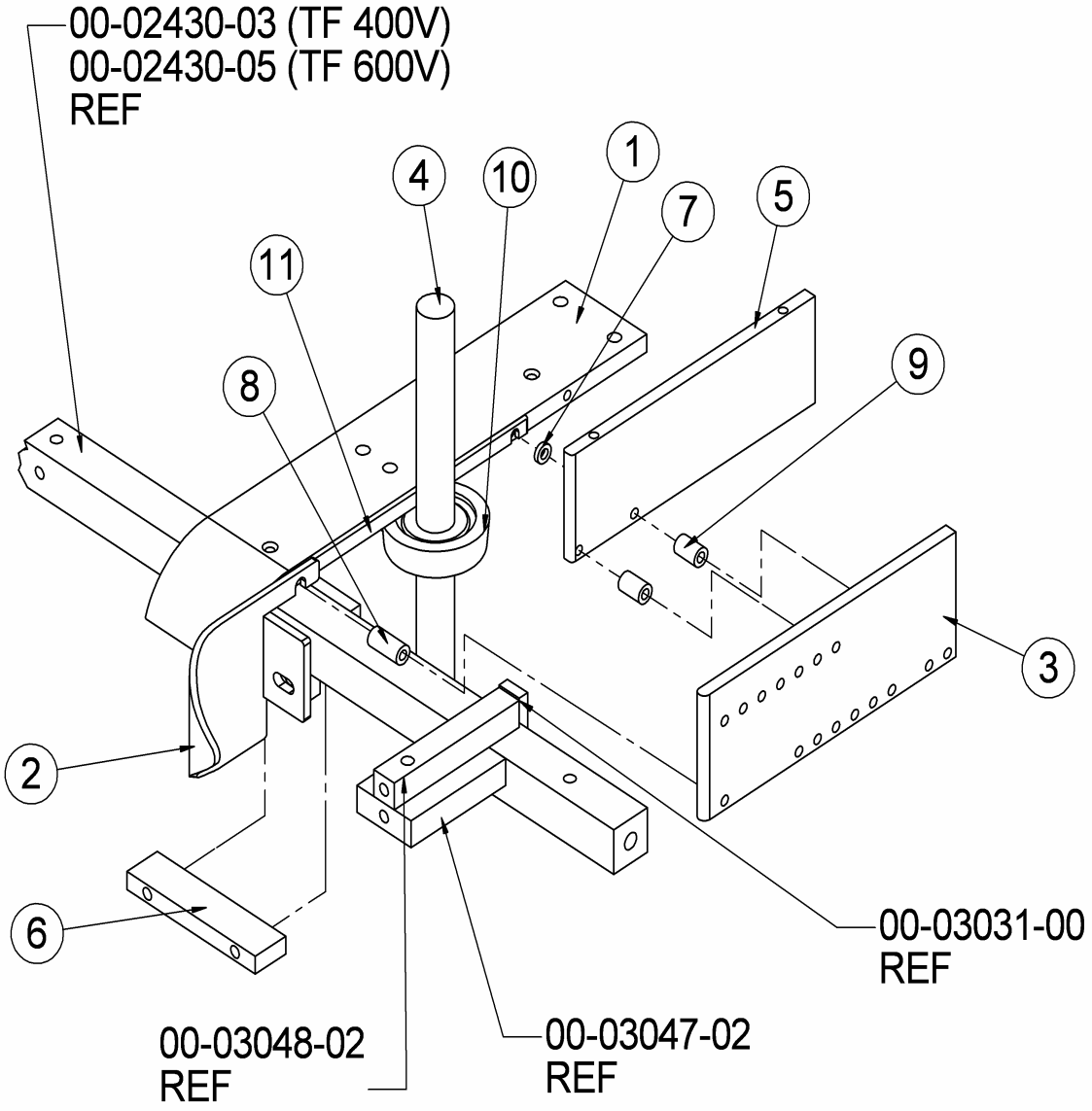
00-03047-02
REF
00-02430-03 (TF 400V)
00-02430-05 (TF 600V)
REF

Minor Flap Folding Plow Assembly (Lower Right Hand Shown)

Item	Qty.	Part No.	Description
1	2R / 2L	00-02785-01	SHOE, TRAY FORMING
2	2R / 2L	00-02927-02	SHOE, TRAY FLANGE FORMING
3	4	00-02933-03	SHOE, TRAY OUTSIDE FLAP FORMNG (ANTI-WIPE)
4	2	00-03057-05	ROD, TRAY FORM COMPRESSION EXTENSION
5	4	00-03514-04	PLATE, TRAY COMPRESSION EXTENSION
6	4	00-03566-00	BAR, SHOE BOX FORMING CLAMP
7	4	02-00499-00	SPACER, 1/2 OD x 17/64 ID x 1/4 LONG
8	4	02-00410-00	SPACER, 1/2 OD x 17/64 ID x 13/16 LONG
9	8	02-00475-00	SPACER, 1/2 OD s 17/64 ID x 3/4 LONG
10	4	05-00065-01	BEARING, COMPRESSION ROD
11	4	00-03209-04	STRIP, SEALING FLAP FORMING


00-02430-03 (TF 400V)
00-02430-05 (TF 600V)
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00-03047-02
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00-03048-02
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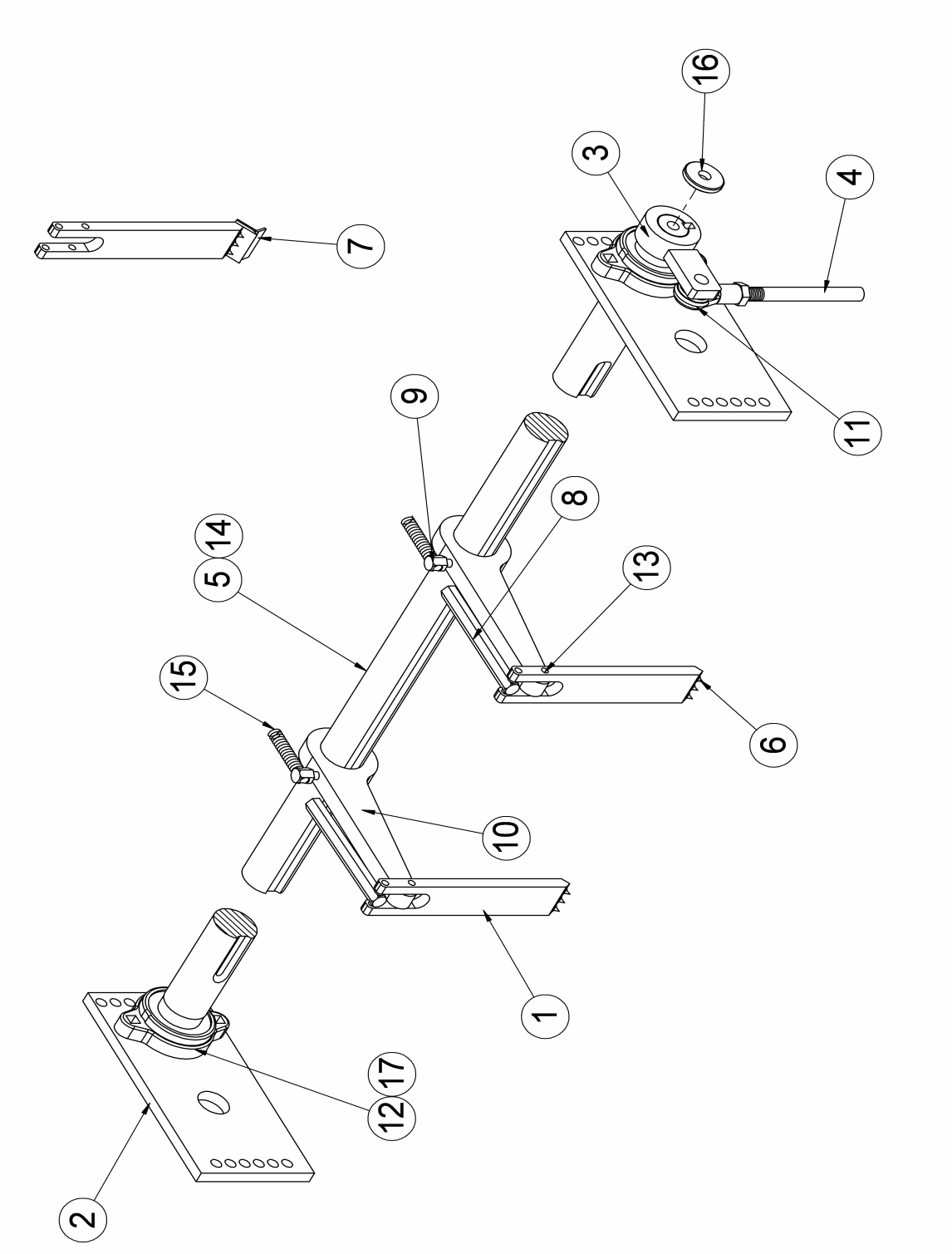
Matt Pick Assembly – (No Vacuum Feed)

Item	Qty.	Part No.	Description
1	2	00-02831-01	PAWL, MATT PICK
2	2	00-02876-03	PLATE, PICK SHAFT BEARING
3	1	00-02877-02	LEVER, MATT PICK OPERATING
4	1	00-02891-01	CON ROD, MATT PICK UPPER SECTION
5	1	00-02895-05	SHAFT, MATT PICK (TF 400V)
	1	00-02895-06	SHAFT, MATT PICK (TF 600V)
6	6	00-02917-00	NEEDLE, MATT PICK
7	2	00-02917-01 & 02	KIT, MATT PICK BLADE
8	2	00-03081-00	ROD END, MATT PICK TENSION
9	2	00-03082-00	EYE, MATT PICK TENSION SPRING BOLT
10	2	00-03450-00	ARM, MATT PICK SHAFT
11	1	05-00051-01	BEARING, ROD END
12	2	05-00070-00	BEARING, TWO HOLE FLANGE PILLOW
13	4	07-00004-02	PIN, MATT PICK PAWL PIVOT
14	1	10-00010-03	KEY, 1/4 x 1/4 x 3/4 LONG
15	2	19-00042-00	SPRING, MATT PICK PAWL
16	1	23-00012-00	WASHER, 1 1/4 OD x 25/64 ID x 3/16 THICK
17	2	23-00056-00	WASHER, 3/4 OD x 21/64 ID x 1/8 THICK

Note: These parts may be purchased as a preassembled package.

To order, specify #60-00164-02 (TF 400V) OR 60-00164-03 (TF 600V).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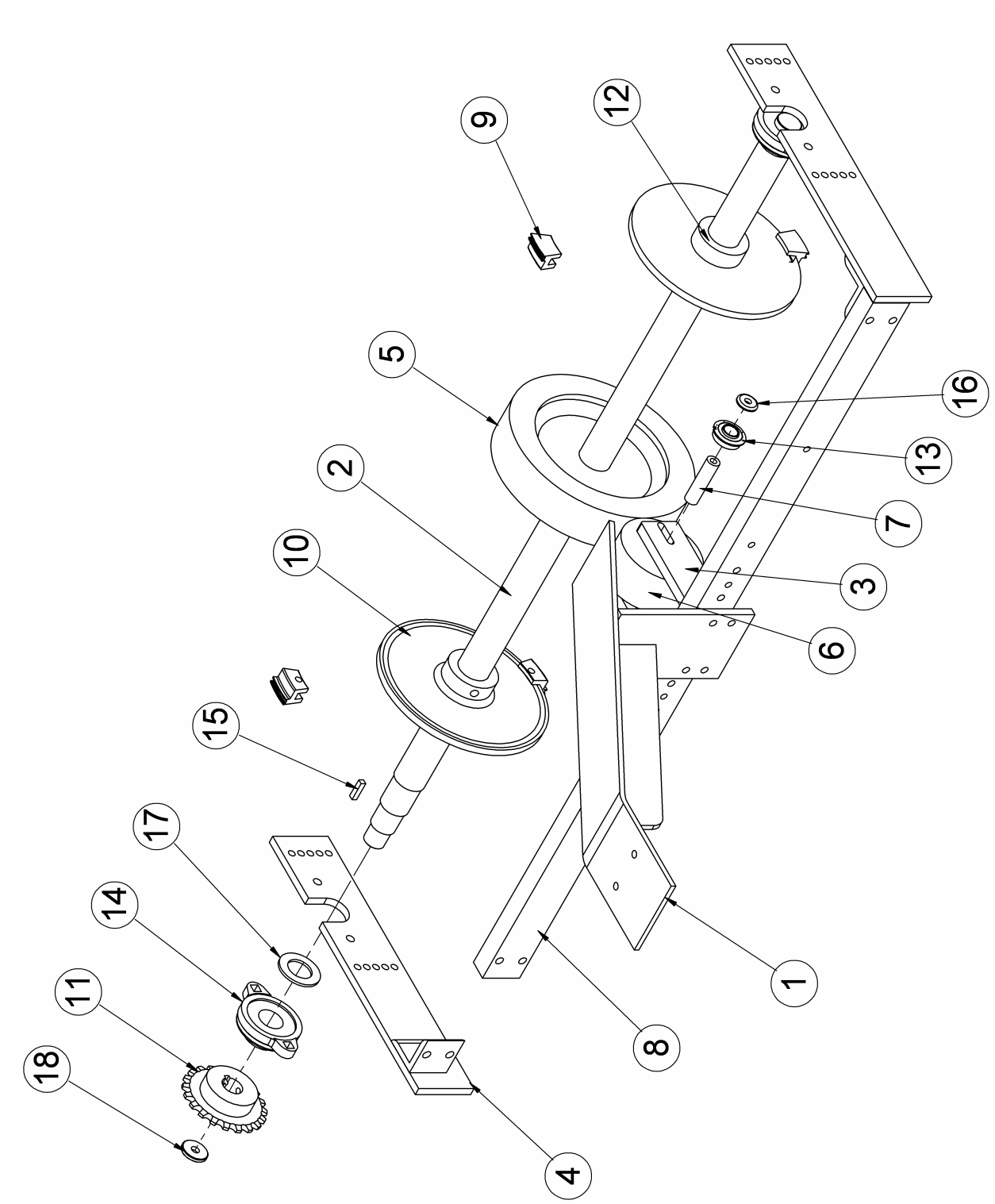
Matt Feed Roll And Programmer Assembly (New style)

Item	Qty.	Part No.	Description
1	1	00-02476-03	SUPPORT, MATT HOPPER LOADING
2	1	00-02832-05	SHAFT, MATT FEED ROLLER (TF 400V)
	1	00-02832-06	SHAFT, MATT FEED ROLLER (TF 600V)
3	2	00-02872-00	MOUNT, MATT FEED IDLE ROLL
4	2R / 2L	00-02900-06	PLATE, MATT FEED WHEEL SHAFT MOUNTING (TF 400V)
	2R / 2L	00-02900-07	PLATE, MATT FEED WHEEL SHAFT MOUNTING (TF 600V)
5	1	00-02906-01	WHEEL, MATT FEED (TF 400V)
	1	00-02906-02	WHEEL, MATT FEED (TF 600V)
6	1	00-02908-00	ROLLER, MATT FEED IDLE
7	1	00-02911-01	SHAFT, MATT FEED IDLE ROLL
8	1	00-02999-04	BAR, MATT FEED IDLE ROLLER MOUNTING (TF 400V)
	1	00-02999-05	BAR, MATT FEED IDLE ROLLER MOUNTING (TF 600V)
*9		00-03028-02	SEGMENT, ADHESIVE APPLICATOR PROGRAM
10	2	00-03029-00	DISC,INTERMITTENT ADHESIVE APP. PROG.(TF 400V)
	2	00-03029-01	DISC,INTERMITTENT ADHESIVE APP. PROG.(TF 600V)
11	1	00-04834-00	SPROCKET, MATT FEED WHEEL SHAFT DRIVE
12	2	01-00015-00	SET COLLAR, ADHESIVE APP. DISC LOCATING (TF 400V)
	2	01-00017-00	SET COLLAR, ADHESIVE APP. (TF 600V)
13	2	05-00038-00	BEARING, MATT FEED IDLE ROLL
14	2	05-00070-01	BEARING, MATT FEED ROLL DRIVE SHAFT
15	1	10-00010-01	KEY, 1/4 x 1/4 x 1 LONG
16	2	23-00001-02	WASHER, 1 O.D. x 5/16 I.D. x 5/32 THICK
17	1	23-00008-00	WASHER, LEVER SHOOK EJECTOR
18	1	23-00012-00	WASHER, 1 1/4 O.D. x 25/64 I.D. x 3/16 THICK

Note: * 4 Required for 2" – 3 ¾" deep trays.
8 Required for 4" – 9" deep trays.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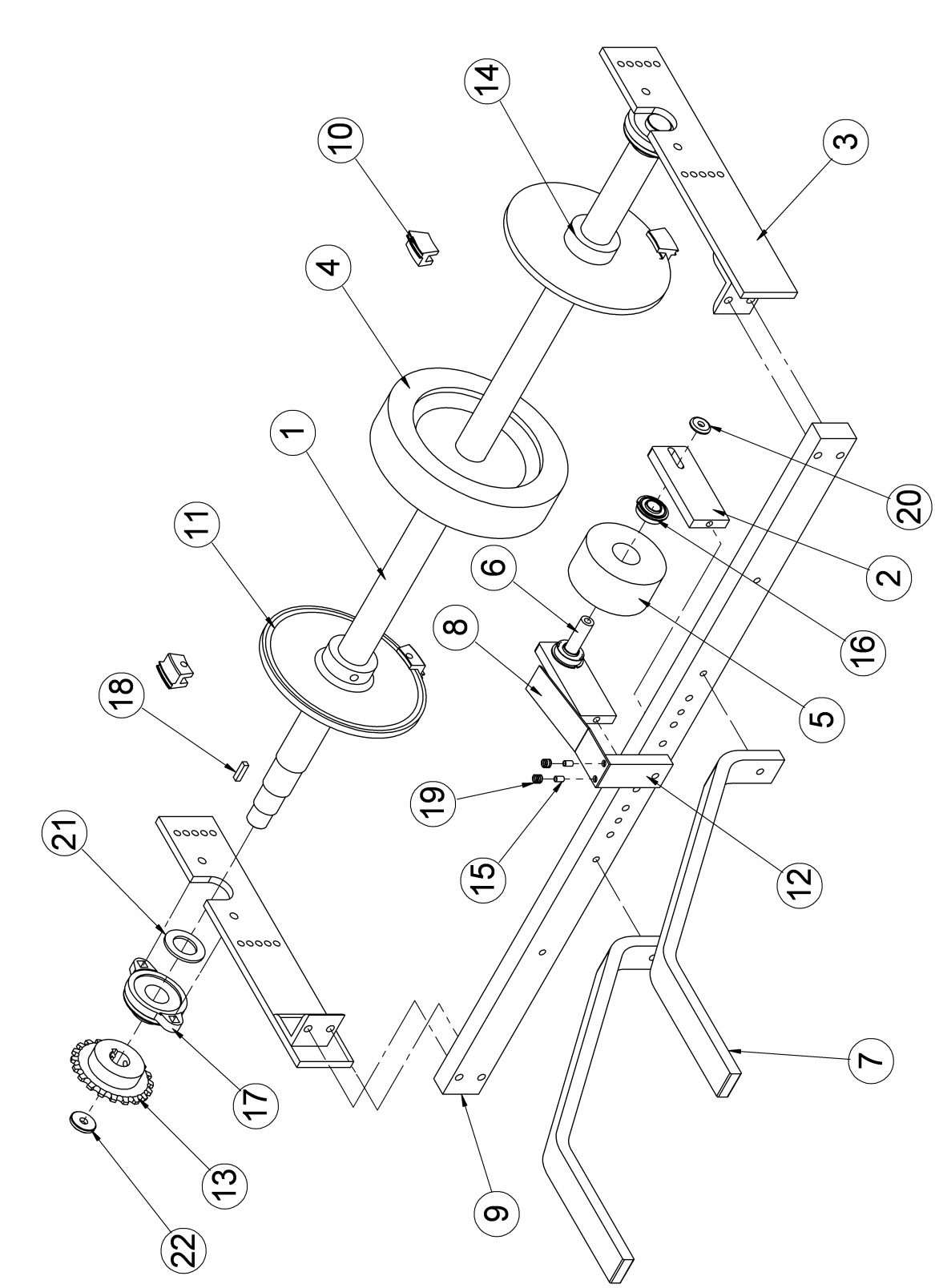
Matt Feed Roll and Programmer Assembly (Old style)

Item	Qty.	Part No.	Description
1	1	00-02832-05	SHAFT, MATT FEED ROLLER (TF 400V)
	1	00-02832-06	SHAFT, MATT FEED ROLLER (TF 600V)
2	2	00-02872-00	MOUNT, MATT FEED IDLE ROLL
3	2R / 2L	00-02900-06	PLATE, MATT FEED TRANSMISSION (TF 400V)
	2R / 2L	00-02900-07	PLATE, MATT FEED TRANSMISSION (TF 600V)
4	1	00-02906-01	WHEEL, MATT FEED (TF 400V)
	1	00-02906-02	WHEEL, MATT FEED (TF 600V)
5	1	00-02908-00	ROLLER, MATT FEED IDLE
6	1	00-02911-01	AXLE, MATT FEED IDLE ROLL
7	2	00-02913-02	SUPPORT, TRAY MATT
8	1	00-02925-00	PAWL, MATT BACK UP
9	1	00-02999-04	BAR, MATT FEED IDLE ROLLER MOUNTING (TF 400V)
	1	00-02999-05	BAR, MATT FEED IDLE ROLLER MOUNTING (TF 600V)
10	*	00-03028-02	SEGMENT, ADHESIVE APPLICATOR PROGRAM
11	2	00-03029-00	DISC,INTERMITTENT ADHESIVE APP. PROGRAM (TF 400V)
	2	00-03029-01	DISC,INTERMITTENT ADHESIVE APP. PROGRAM (TF 600V)
12	1	00-03050-00	BRACKET, MATT BACK UP PAWL
13	1	00-04834-00	SPROCKET, MATT FEED WHEEL SHAFT DRIVE (40B24)
14	2	01-00015-00	SET COLLAR, ADHESIVE APPLICATOR DISC LOCATING
15	2	02-00039-00	BUSHING, PAWL HOLDING
16	2	05-00038-00	BEARING, MATT FEED IDLE ROLL
17	2	05-00070-01	BEARING, MATT FEED ROLL DRIVE SHAFT
18	1	10-00010-01	KEY, 1/4 x 1/4 x 1 LONG
19	2	19-00037-00	SPRING, PAWL HOLDING
20	2	23-00001-02	WASHER, 1 OD x 5/16 ID x 5/32 THICK
21	1	23-00008-00	WASHER, 1 1/4 OD x 25/64 ID x 3/16 THICK
22	1	23-00012-00	WASHER, FOR LEVER SHOOK EJECTOR

Note: * 4 Required for 2" - 3 ¾ " deep trays.
8 Required for 4" – 9" deep trays.
To order the matt feed idler roller assembly as a preassembled package specify #60-00179-00.
To order the matt feed roll shaft assembly as a preassembled package specify #60-00167-04.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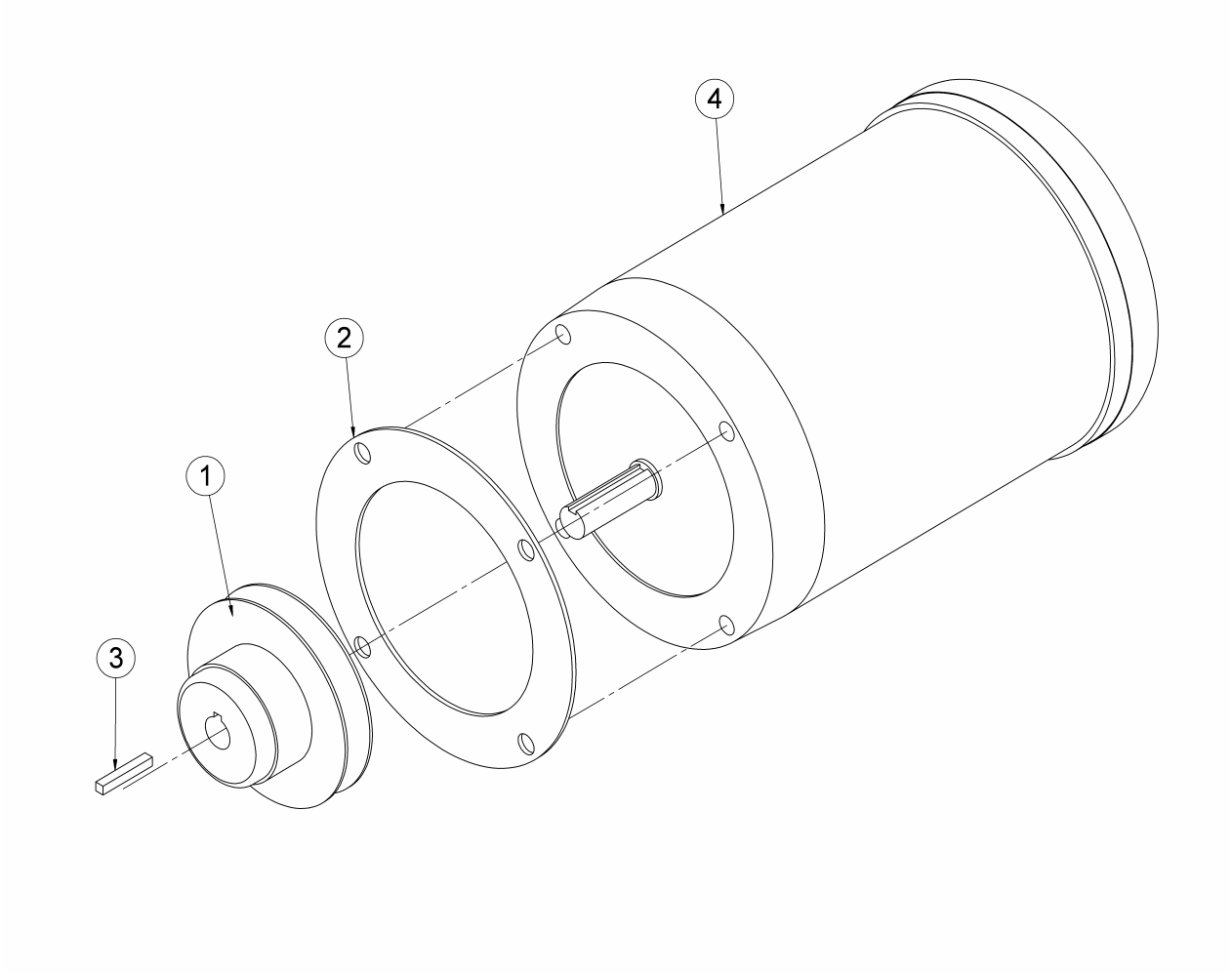
V-Belt Drive Assembly

Item	Qty.	Part No.	Description
1	1	*00-03231-00	PULLEY, VARI-DRIVE MOTOR, 12-35 OR 21/58 TPM SPEED
		*00-03231-00	PULLEY, VARI-DRIVE MOTOR, 29-70 TPM
			(TRAYS PER MINUTE) SPEED
2	1	00-08878-00	
3	1	10-00009-04	KEY, VARI-DRIVE PULLEY
4	1	13-00005-04	MOTOR, 1 HP, 1140 RPM, BALDOR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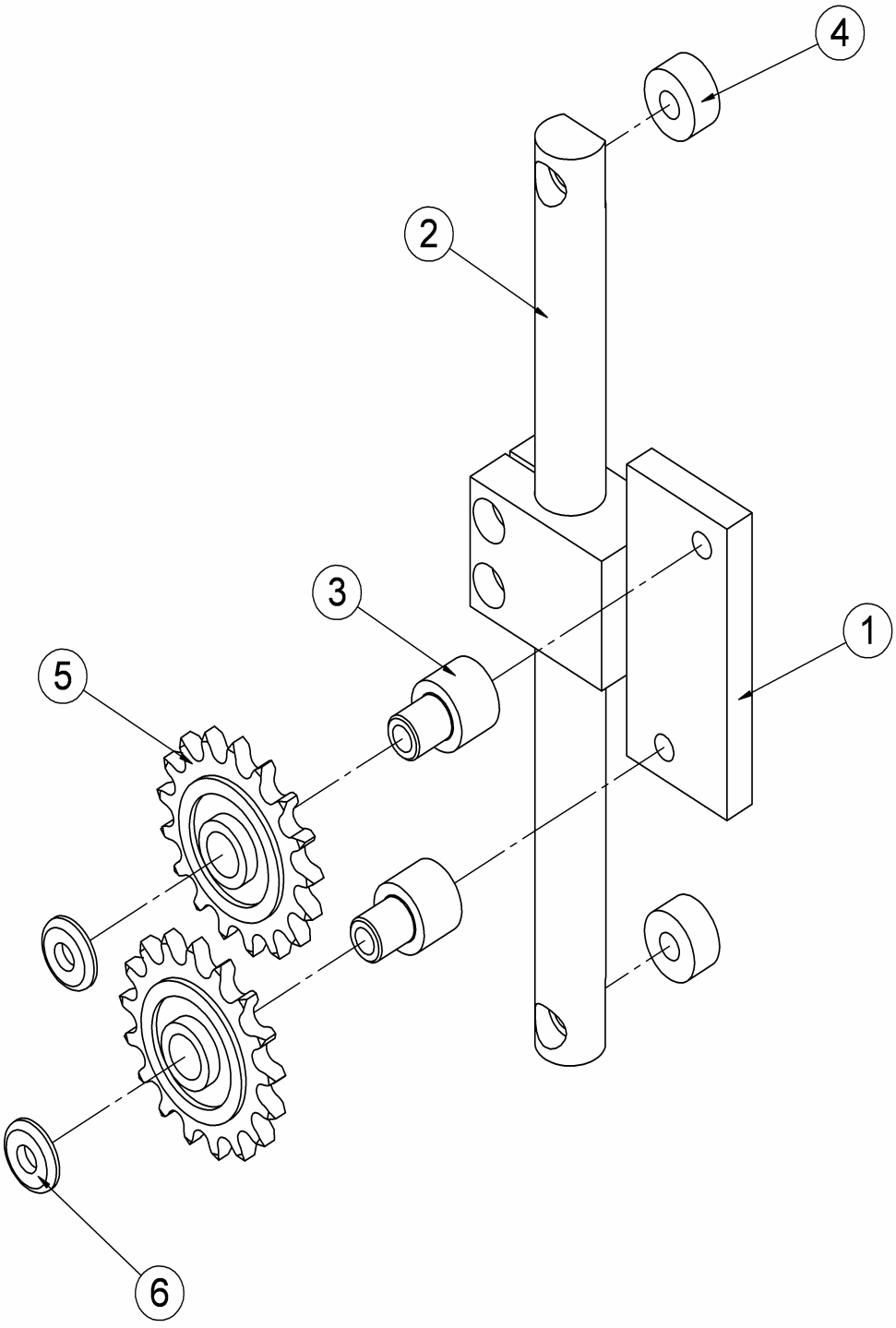
Take-up Chain Idler Assembly

Item	Qty.	Part No.	Description
1	1	00-04934-00	MOUNT, IDLE SPROCKET TAKE-UP
2	1	00-04935-00	BAR, IDLE SPROCKET TAKE-UP MOUNT
3	2	00-07270-00	AXLE, IDLE SPROCKET
4	2	02-00064-00	BUSHING, 1 OD x 25/64 ID x 1/2 LONG
5	2	03-00009-01	SPROCKET, IDLE TAKE-UP
6	2	23-00001-01	WASHER, 1 OD x 25/64 ID x 5/32 LONG

Note: These parts may be purchased as a preassembled package. To order, specify #60-00171-02.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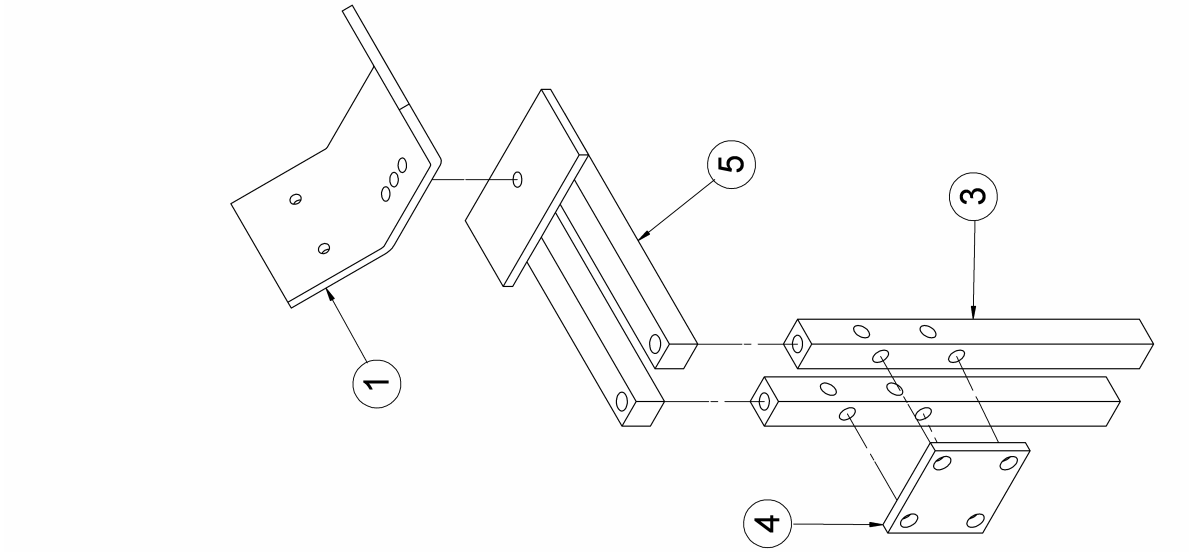
Matt Bottom Stop Assembly

Item	Qty.	Part No.	Description
1	1R / 1L	00-03465-02	STOP, TRAY BOTTOM
2	1	00-03565-00	EXTENSION, MATT STOP BRACKET
3	2	00-07183-00	BAR, MATT STOP PLATE SUPPORT
4	1	00-07184-00	MOUNT, MATT STOP SUPPORT BAR
5	1	00-07185-00	BRACKET, MATT STOP

Note: These parts may be purchased as a preassembled package.

To order, specify #60-00175-02, right or left.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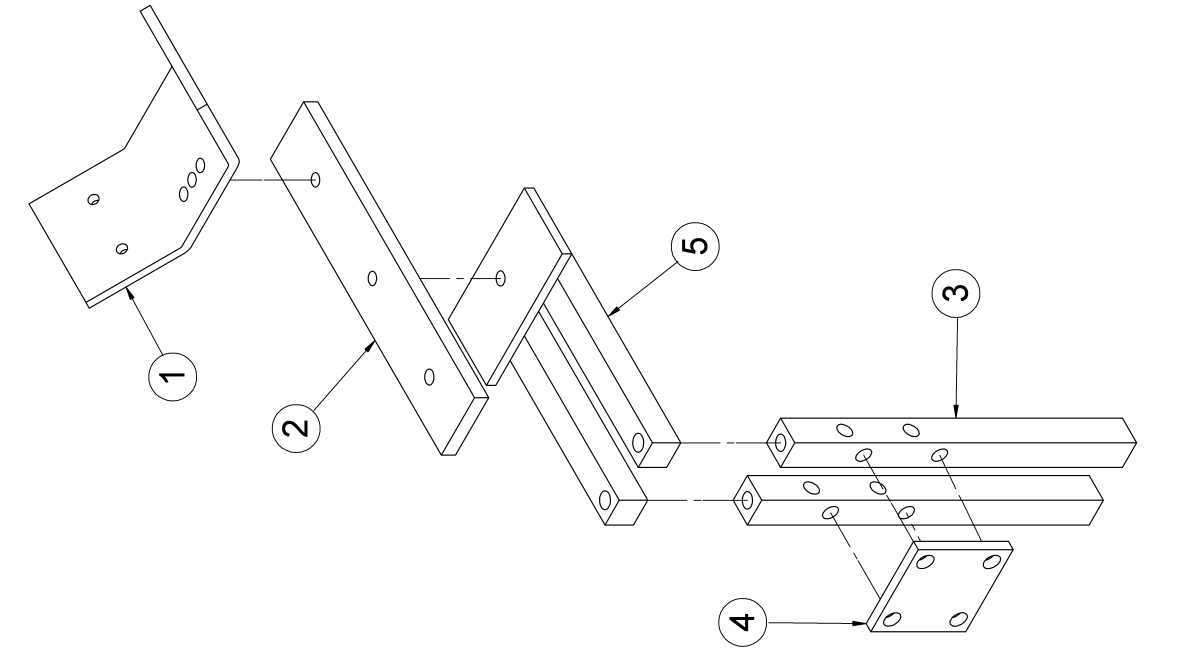
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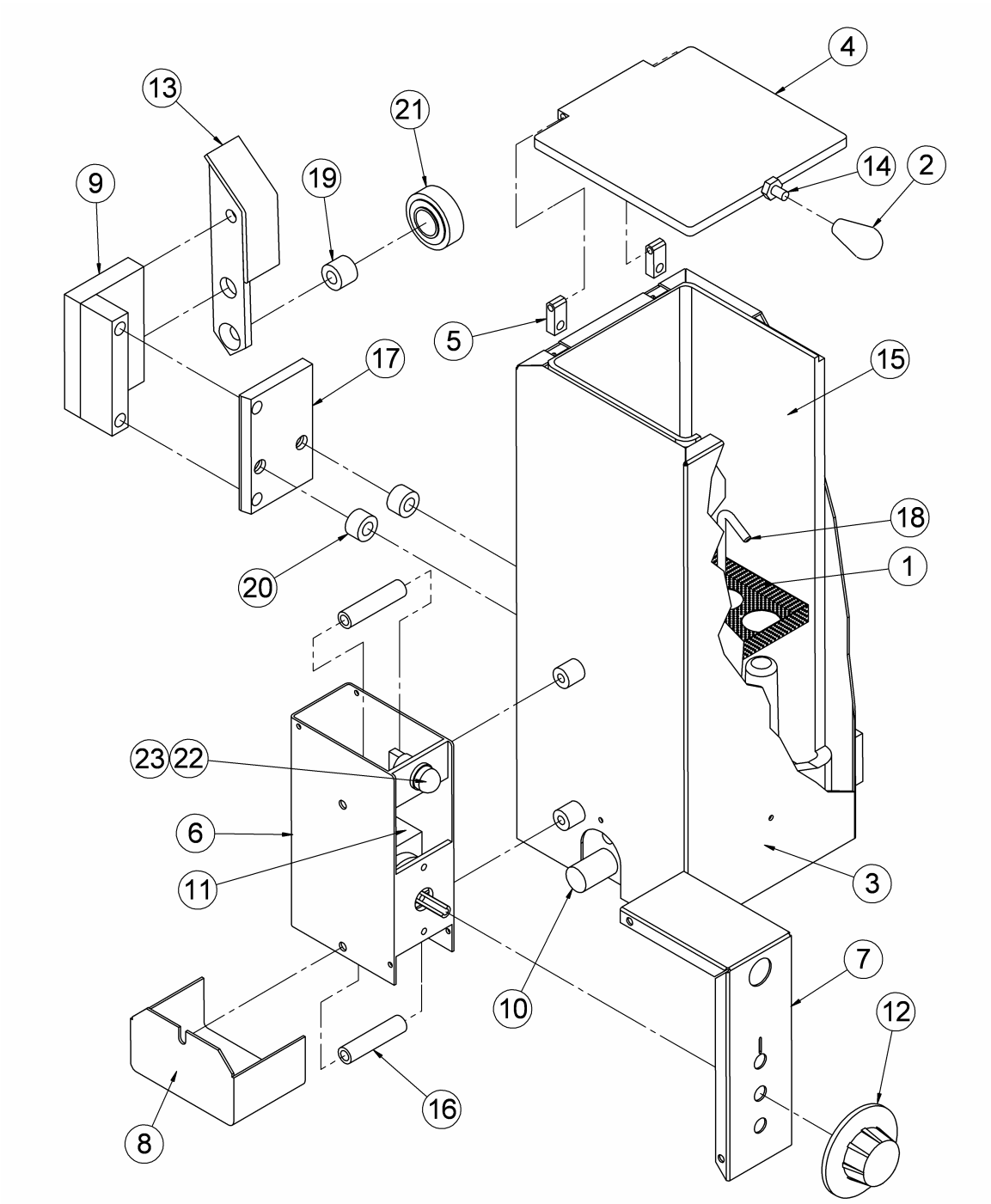
Adhesive Melt Pot Assembly

Item	Qty.	Part No.	Description
~1	1	00-02743-00	SCREEN, ADHESIVE MELT
~2	1	00-02758-00	KNOB, ADHESIVE MELT POT COVER
~3	1R / 1L	00-02781-01	SHROUD, ADHESIVE MELT POT
~4	1	00-02782-00	COVER, ADHESIVE MELT POT
~5	2	00-2853-00	HINGE, ADHESIVE MELT POT COVER
~6	1	00-02873-02	BOX, THERMOSTAT CONTROL
~7	1	00-02874-02	COVER, ADHESIVE MELT THERMOSTAT
~8	1	00-02936-01	GUARD, THERMOSTAT WIRE
~9	1R / 1L	00-02967-00	CLAMP, ADHESIVE MELT POT MOUNTING
~10	1	*00-02997-00	HEATER, ADHESIVE MELT POT
~11	1	00-02998-02	THERMOSTAT, ADHESIVE MELT POT
~12		40-02998-02	PART OF 00-02998-02 THERMOSTAT
~13	1R / 1L	00-03064-01	BAR, MELT POT CLAMP
~14	1	00-03067-00	STUD, MELT POT COVER KNOB
~15	1R / 1L	00-03089-01	POT, ADHESIVE MELT
~16	2	00-03092-00	SPREADER, THERMOSTAT CONTROL BOX
~17	1R / 1L	00-03130-00	PLATE, ADHESIVE MELT POT MOUNTING
~18	1	00-03508-02	HANDLE, ADHESIVE MELT SCREEN
~19	1	02-00144-00	BUSHING
~20	2	02-00272-00	BUSHING, ADHESIVE MELT POT MOUNTING
~21	1	05-00019-00	BEARING
~22	1	22-00006-01	LIGHT, INDICATOR ASSEMBLY
~23	1	22-00006-02	LAMP, INDICATOR

Note: ~ These parts may be purchased as a preassembled package.

To order, specify #60-00199-01 right or left.

* Variable part – order by manufacturers number on heater and length.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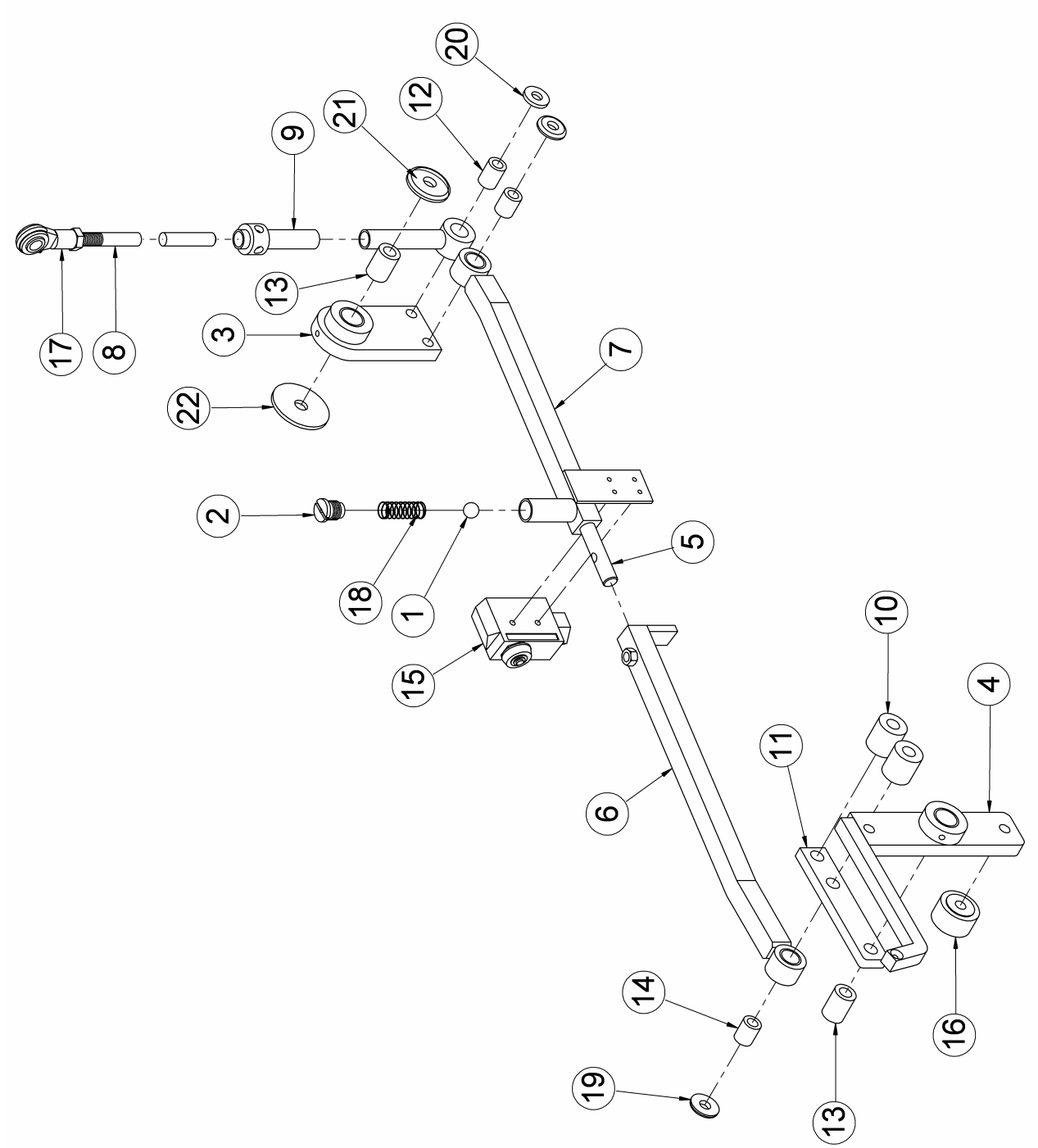
Matt Pick Safety Assembly – (No Vacuum Feed)

Item	Qty.	Part No.	Description
1	1	00-00967-01	BALL, MATT PICK SAFETY DETENTION
2	1	00-01371-01	PLUG, MATT PICK DETENTION SPRING
3	1	00-02848-00	ARM, MATT FEED LINKAGE
4	1	00-02857-00	ARM, MATT PICK CAM FOLLOWER
5	1	00-02858-00	ROD, MATT FEED LINKAGE SAFETY
6	1	00-02859-00	BAR, MATT FEED LINKAGE REAR SAFETY
7	1	00-02860-01	BAR, MATT FEED LINKAGE FRONT SAFETY
8	1	00-02891-01	CON ROD, MATT PICK UPPER SECTION
9	1	00-02893-02	CON ROD, MATT PICK LOWER SECTION
10	2	00-04825-01	BLOCK, MATT PICK STRAP MOUNTING
11	1	00-04826-00	STRAP, MATT PICK LEVER MOUNTING
12	1	02-00033-00	BUSHING, 5/8 OD x .377 ID x 27/32 LONG
13	2	02-00185-00	BUSHING, 3/4 OD x 7/16 ID x 1 1/32 LONG
14	2	02-00435-00	BUSHING, 5/8 OD x 3/8 ID x 49/64 LONG
15	1	04-00010-02	MICRO SWITCH, PICK SAFETY
16	1	05-00039-00	BEARING, PICK CAM FOLLOWER ROLL
17	1	05-00051-01	BEARING, ROD END
18	1	19-00084-00	SPRING, PICK SAFETY DETENT
19	2	23-00001-01	WASHER, 1 OD x 25/64 ID x 5/32 THICK
20	1	23-00004-00	WASHER, 55/64 OD x 3/8 ID x 1/8 THICK
21	1	23-00017-00	WASHER, 1 1/2 OD x 7/16 ID x 3/16 THICK
22	1	23-00055-00	WASHER, 2 OD x 7/16 ID x 1/8 THICK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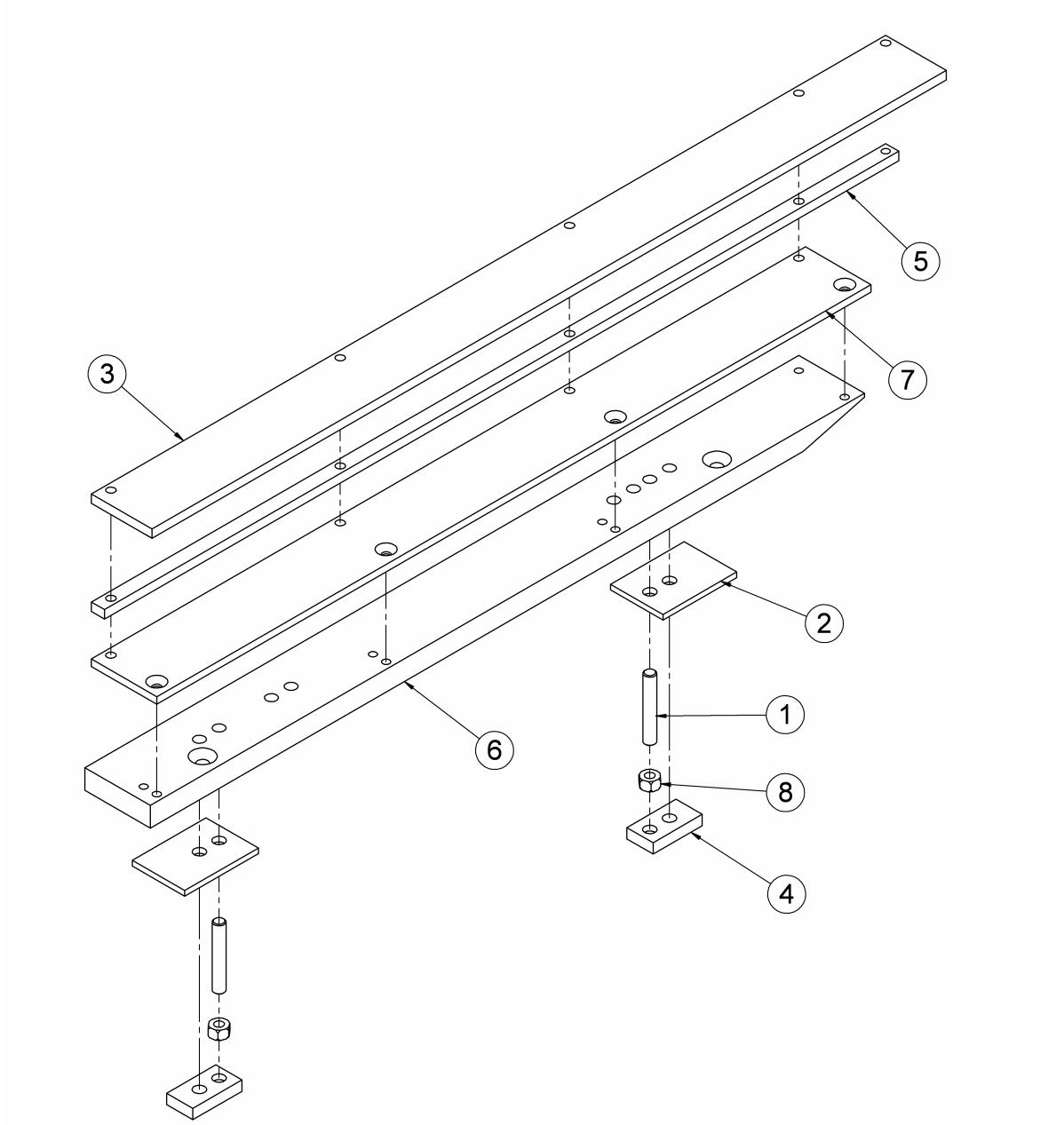
Tray Mandrel Guide Rail Assembly

Item	Qty.	Part No.	Description
1	2	00-02942-04	STUD, CLAMP SUPPORT
2	2	00-03024-01	SPACER, TRAY FORMER MANDREL BASE
			FOR "B & C" FLUTE
	2	00-03024-02	SPACER, TRAY FORMER MANDREL BASE
			FOR "A" FLUTE
	2	00-03024-03	SPACER, TRAY FORMER MANDREL BASE
			FOR B/C DOUBLEWALL
3	1	00-03027-01	CAP, TRAY FORMER MANDREL GUIDE PLATE
4	2	00-03030-00	PLATE, TRAY FORMER MANDREL BASE CLAMP
5	1	00-03032-01	SHIM, TRAY FORMER MANDREL GUIDE CAP PLATE
6	1R / 1L	00-03034-01	BASE, TRAY FORMER MANDREL GUIDE
7	1	00-03203-00	GIB, TRAY FORMER MANDREL BASE
8	2		HEX NUT 3/8 N/C

Note: These parts may be purchased as a preassembled package.

To order, specify #60-00169-01 right or left.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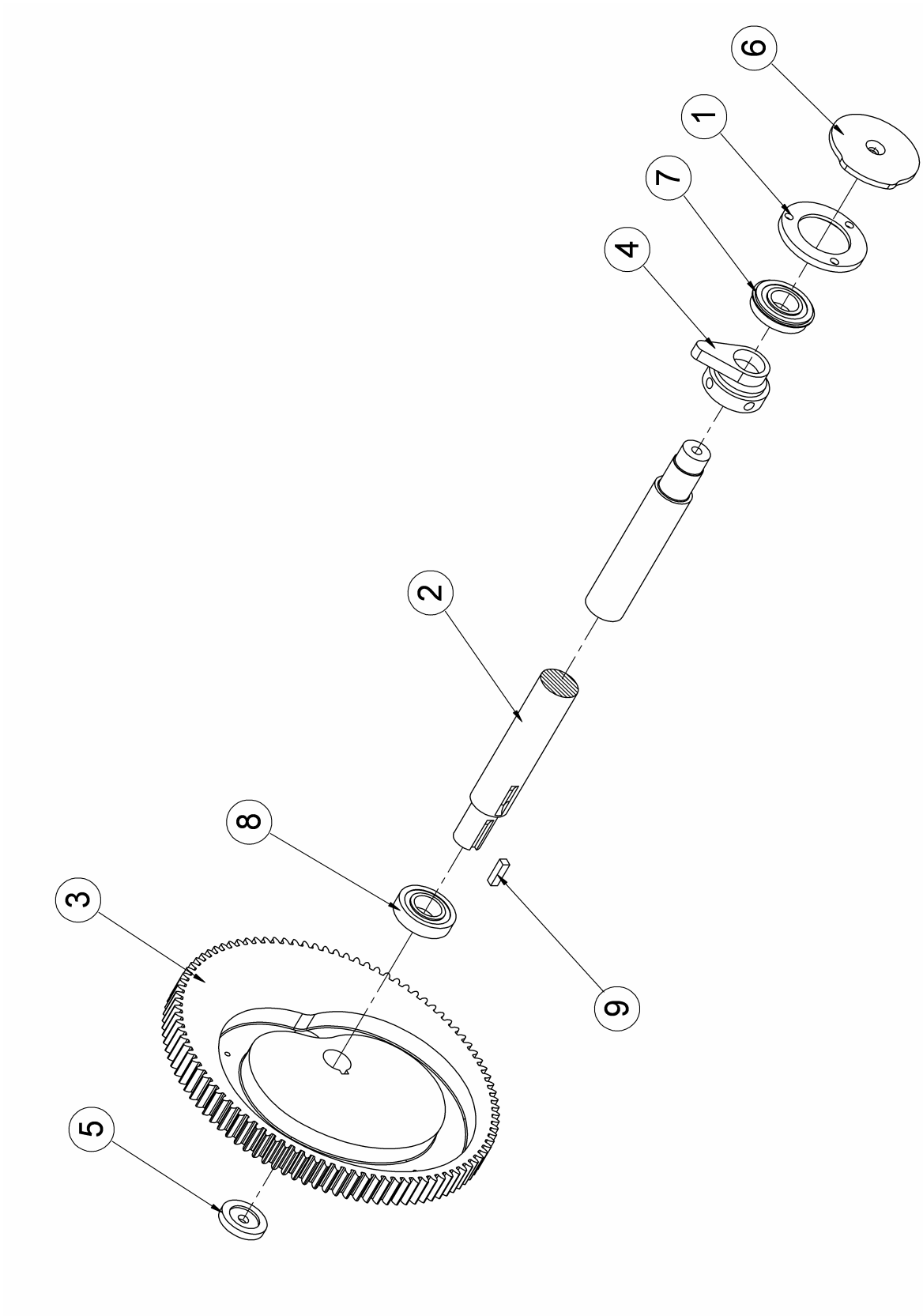
Transmission Gear Shaft Assembly – Matt Pick

Item	Qty.	Part No.	Description
1	1	00-02447-00	RING, MAIN SHAFT BEARING CLAMP
2	1	00-02508-02	SHAFT, TRANSMISSION GEAR (TF 400V)
	1	00-02508-03	SHAFT, TRANSMISSION GEAR (TF 600V)
3	1	00-02619-01	GEAR, TRANSMISSION MAIN
4	1	00-02855-02	CAM, MATT PICK OPERATING
5	1	00-03197-00	WASHER, MAIN DRIVE GEAR RETENTION
6	1	00-03245-01	CAM, CYCLE MICRO LIMIT SWITCH
7	1	05-00002-00	BEARING, TRANSMISSION SHAFT R.H.
8	1	05-00003-00	BEARING, TRANSMISSION SHAFT L.H.
9	1	10-00012-01	KEY, TRANSMISSION MAIN GEAR 3/8 x 3/8 x 1 3/8 LONG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Feed Post Shaft Assembly

Item	Qty.	Part No.	Description
1	1	00-02444-00	RING, BEARING CLAMP
2	1	00-04839-01	SHAFT, MANDREL CRANK ARM (TF 400V)
	1	00-04861-00	SHAFT, MANDREL CRANK ARM (TF 600V)
3	1	00-04899-00	FEED POST MANDREL
4	1	05-00013-00	BEARING FEED POST SHAFT R.H.
5	1	05-00013-01	BEARING FEED POST SHAFT L.H.
6	1	05-00043-03	CAM FOLLOWER ROLLER FEED POST
7	1	23-00012-00	WASHER, 1 1/4 OD x 3/8 ID x 3/16" LONG

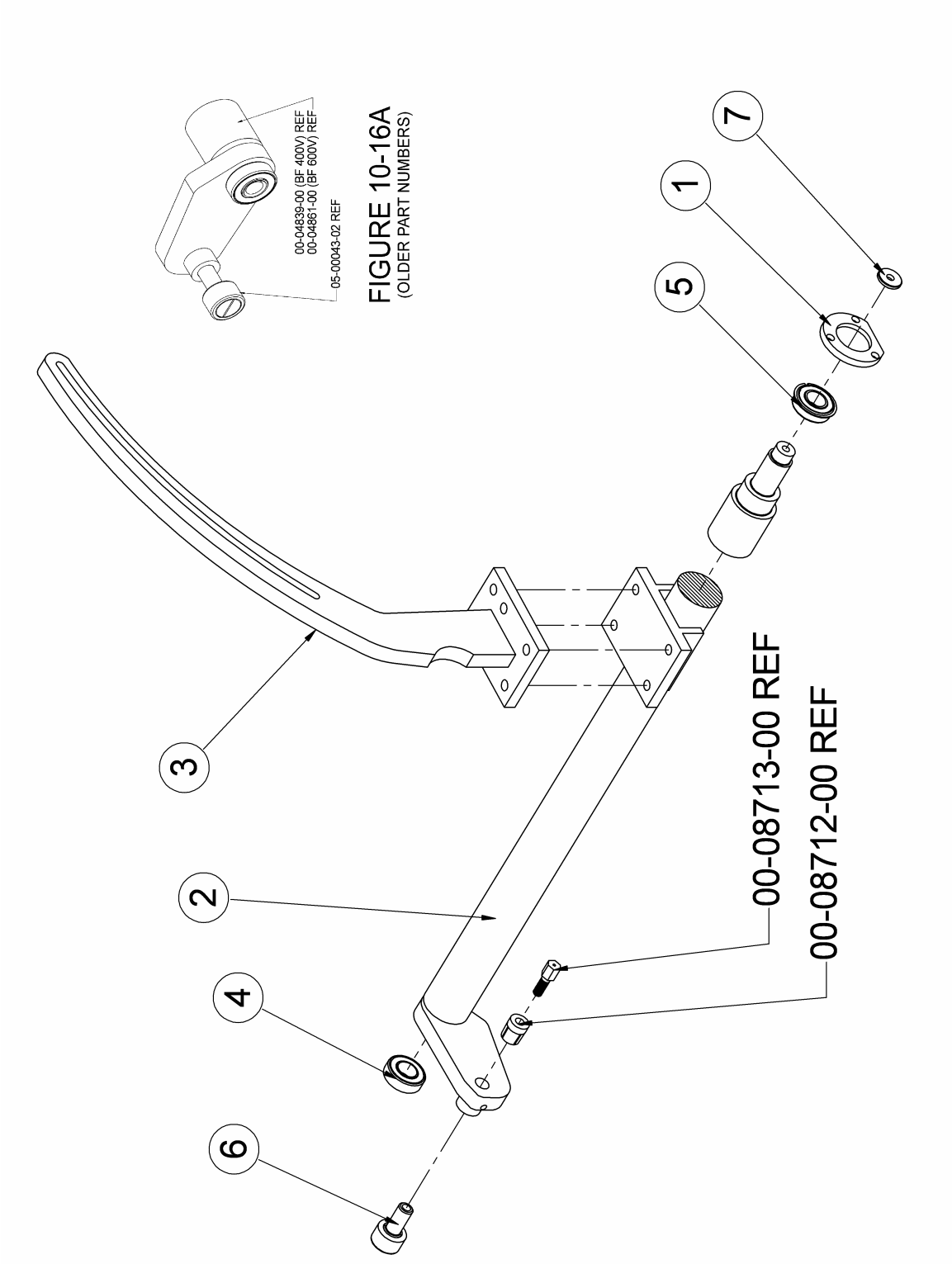
FIGURE 10-16A
(OLDER PART NUMBERS)
00-04839-00 (BF 400V) REF
00-04861-00 (BF 600V) REF
05-00043-02 REF
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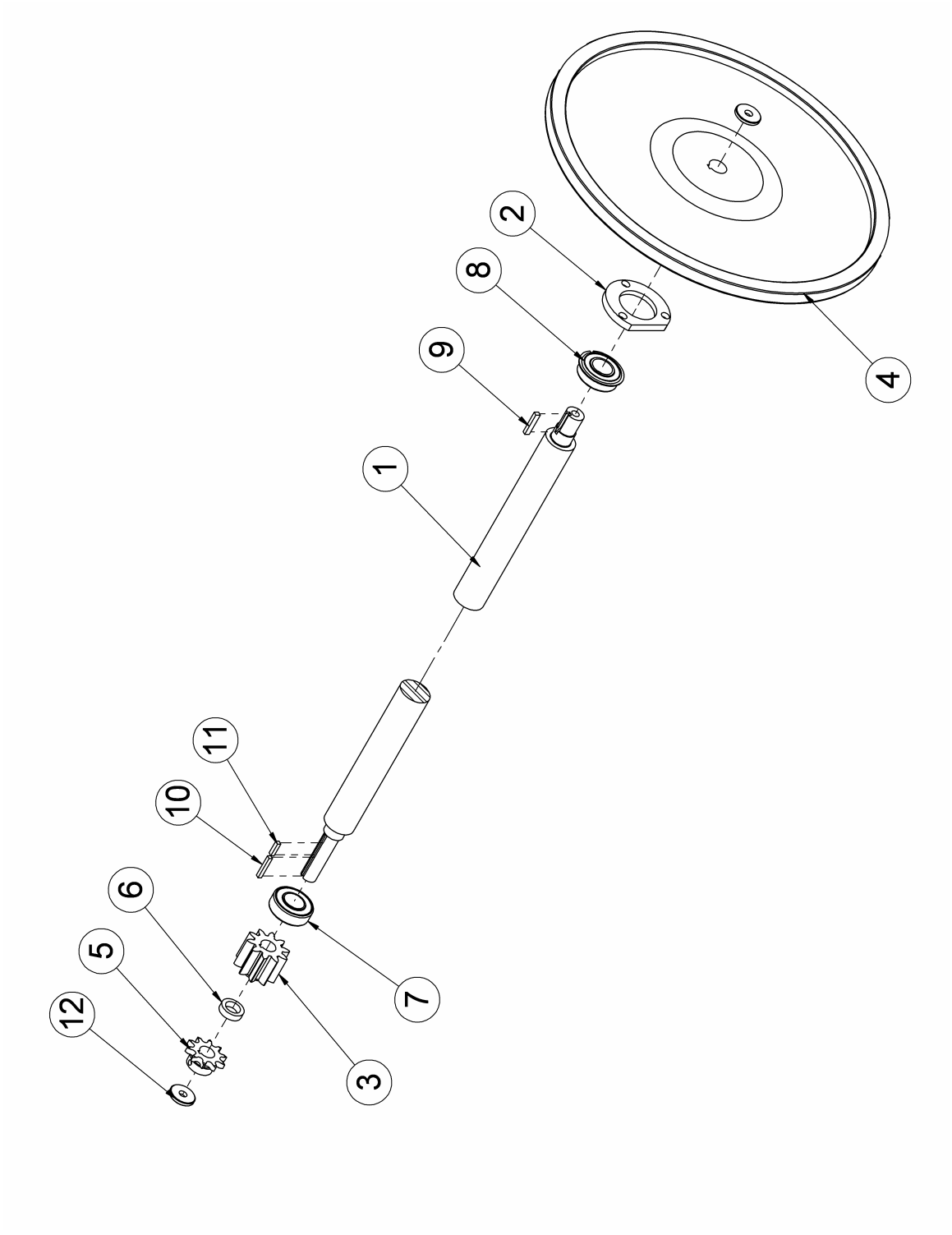
00-08713-00 REF
00-08712-00 REF

Pinion Shaft Assembly

Item	Qty.	Part No.	Description
1	1	00-02443-02	SHAFT, TRANSMISSION PINION (TF 400V)
	1	00-02443-03	SHAFT, TRANSMISSION PINION (TF 600V)
2	1	00-02444-00	RING, PINION SHAFT BEARING CLAMP
3	1	00-02456-00	PINION, TRANSMISSION
4	1	*00-03218-00	PULLEY, PINION SHAFT …. 12-35
	1	00-03218-01	PULLEY, PINION SHAFT …. 21-58
5	1	00-07299-00	SPROCKET, MATT FEED ROLL CHAIN (40B10)
6	1	02-00379-00	SPACER, PINION SHAFT SPROCKET
			1 1/8 OD x 3/4 ID x 5/16 LONG
7	1	05-00013-00	BEARING, PINION SHAFT L.H.
8	1	05-00013-01	BEARING, PINION SHAFT R.H.
9	1	10-00006-00	KEY, PINION PULLEY 1/4 x 3/16 x 1 LONG
10	1	10-00009-01	KEY, MATT FEED ROLL DRIVE SPROCKET
			3/16 x 3/16 x 3/4 LONG
11	1	10-00009-04	KEY, TRANSMISSION PINION GEAR
			3/16 x 3/16 x 1 1/4 LONG
12	2	23-00012-00	WASHER, 1 1/2 OD x 3/8 ID x 3/16 THICK

* Refer to machine order part number.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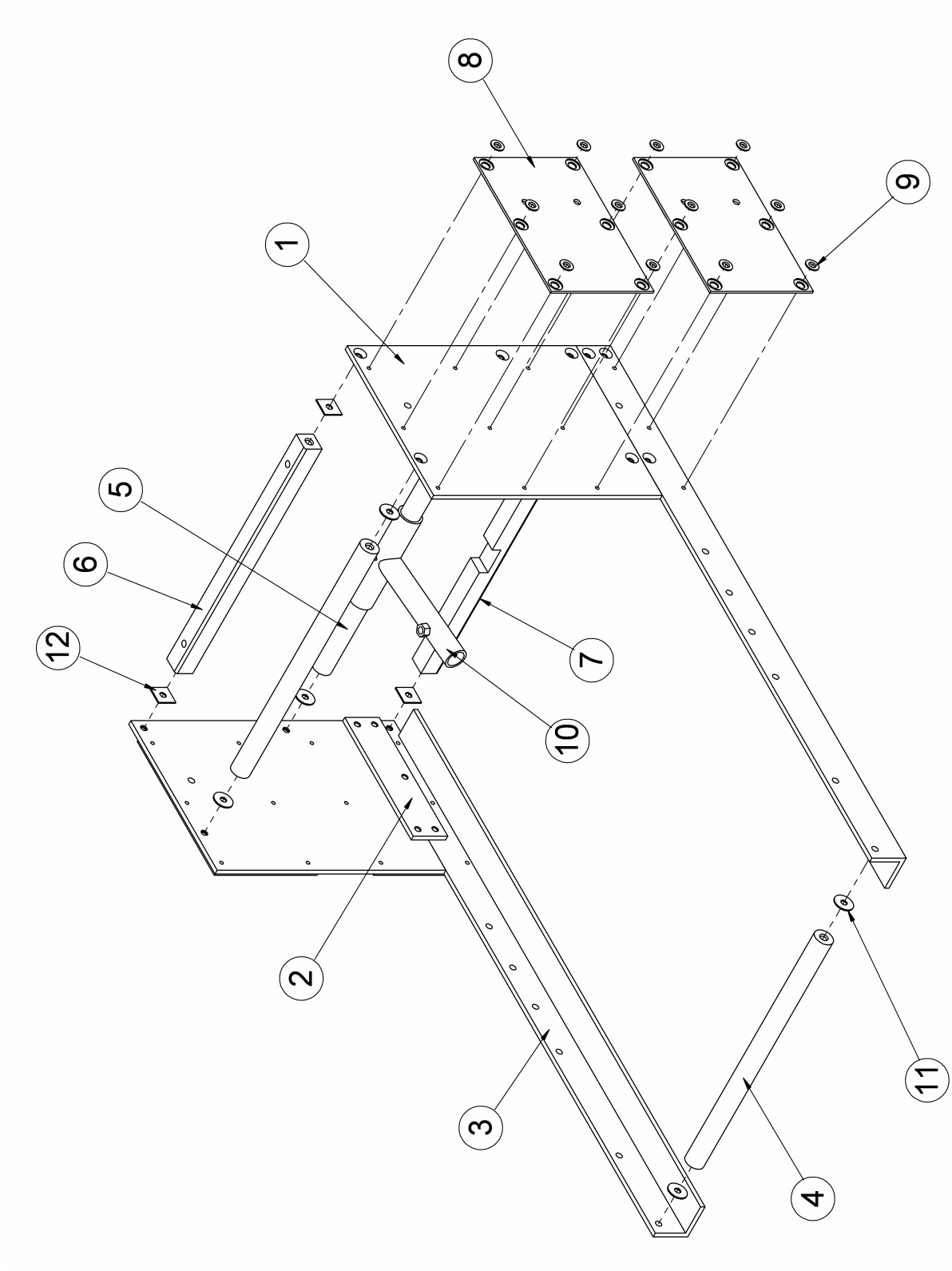
Tray Forming Mandrel Assembly

Item	Qty.	Part No.	Description
1	1R / 1L	00-03035-00	PLATE, TRAY MANDREL SIDE
2	2	00-03043-00	PLATE, MANDREL FRAME PLATE MOUNTING
3	1R / 1L	00-03046-01	RAIL, TRAY FORM MANDREL
4	2	00-03083-00	SHAFT, MANDREL SPREADER (ALUMINUM)
5	1	00-03083-01	SHAFT, MANDREL CON ROD PIVOT (STAINLESS STEEL)
6	1	00-03085-01	BAR, MANDREL SPREADER (SQUARE)
7	1	00-03085-02	BAR, MANDREL SPREADER (SQUARE)
8	4	00-03311-01	SHEET, TEFLON MANDREL COVER
9	24	00-03463-00	WASHER, TEFLON CLAMP
10	1	00-03603-00	END, MANDREL CON ROD
11	6	23-00066-00	WASHER, 1 O.D. x 21/64 x 1/16 THICK
12	4	23-00088-00	WASHER, MANDREL SPACER, 16 GA. x 1 x 1 LONG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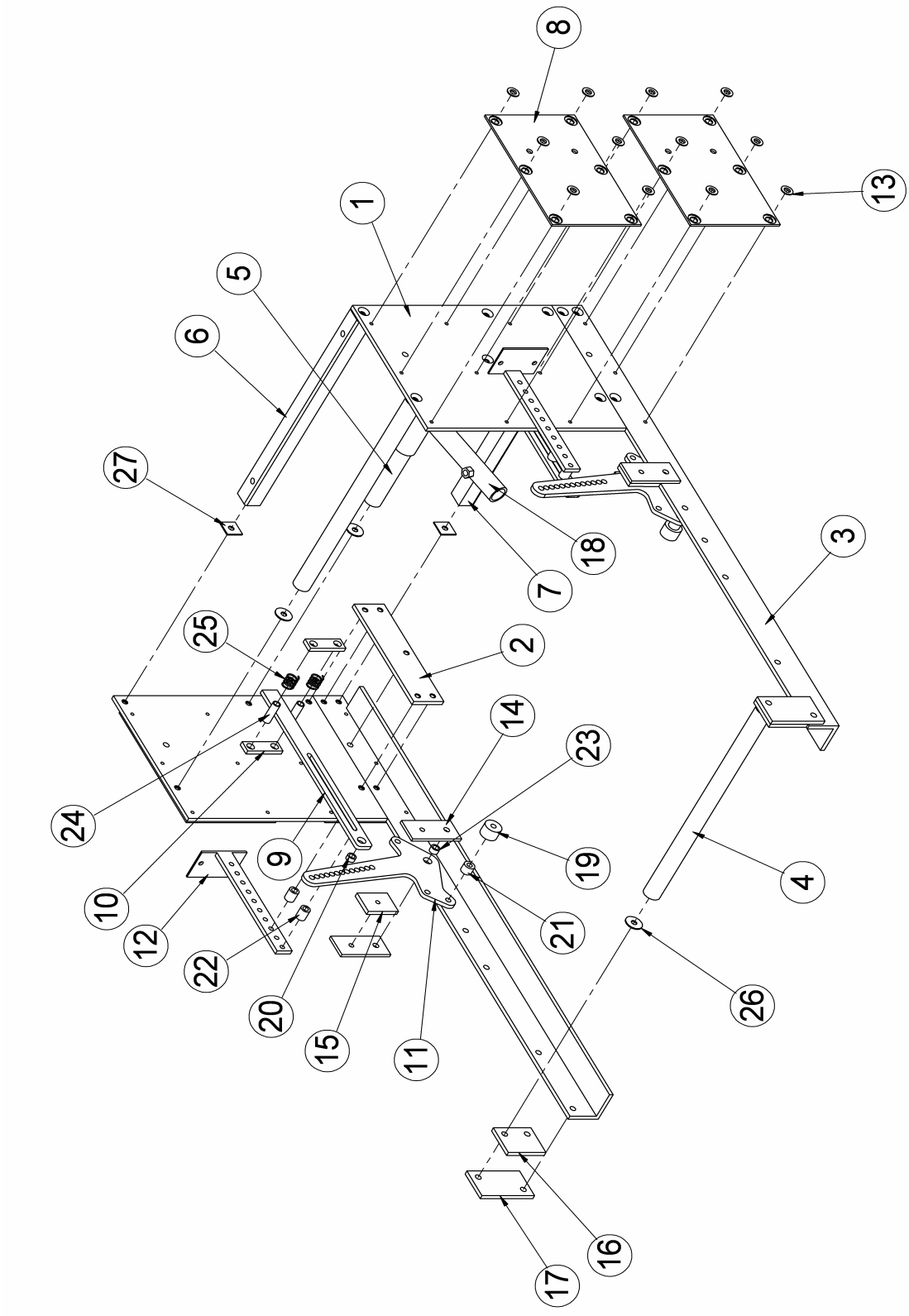
Tray Forming Mandrel with Pushers Assembly

Item	Qty.	Part No.	Description
*1	1R / 1L	00-03035-00	PLATE, TRAY FORMING MANDREL SIDE
2	2	00-03043-00	TRAY PLATE MANDREL FRAME PLATE MOUNTING
*3	1R / 1L	00-03046-01	RAIL, TRAY FORM MANDREL
*4	2	00-03083-00	SHAFT, MANDREL SPREADER
*5	1	00-03083-01	SHAFT, CON ROD PIVOT
*6	1	00-03085-01	BAR, MANDREL SPREADER SQUARE
*7	1	00-03085-02	BAR, MANDREL SPREADER SQUARE
*8	4	00-03311A-Z	SHEET, TEFLON COVER
*9	2	00-03453-01	BAR, LID FLAP PUSHER
*10	4	00-03454-02	GUIDE, LID FLAP PUSHER BAR
11	2	00-03455-01	ARM, TRAY FLAP PUSHER
12	2	00-03457-02	PAWL, TRAY FLAP PUSHER
13	24	00-03463-00	WASHER, TEFLON CLAMP
14	4	00-03515-00	PLATE, PUSHER ARM GUIDE
15	2	00-03516-00	SHOE, PUSHER ARM GUIDE PLATE
16	2	00-03600-00	SHIM, REAR MANDREL SPACER ROD ELEVATING
17	2	00-03600-01	PLATE, REAR MANDREL SPACER ROD ELEVATING
18	1	00-03603-00	END, MANDREL CON ROD
19	2	02-00083-00	CAM, FOLLOWER BRG. 1 OD x 5/16 ID x .6875+ .005/ -.000
20	2	02-00104-00	BUSHING, 1/2 OD x 21/64 ID x 17/64 LONG
21	2	02-00144-00	SPACER, CAM ROLLER 5/8 OD x 5/16 ID x 1/2 LONG
22	4	02-00196-00	SPACER, 9/16 OD x 21/64 ID x 11/16 LONG
23	2	02-00206-00	BUSHING, 1/2 OD x 21/64 ID x 5/16 LONG
24	4	02-00331-00	SPACER, 7/16 OD x 21/64 ID x 1 3/8 LONG
25	4	19-00143-00	SPRING, LID PUSHER BAR GUIDE CLAMP
26	6	23-00066-00	WASHER, 1 OD x 21/64 ID x 1/16 THICK
27	4	23-00088-00	WASHER, MANDREL SPACER

Note: * Made to order.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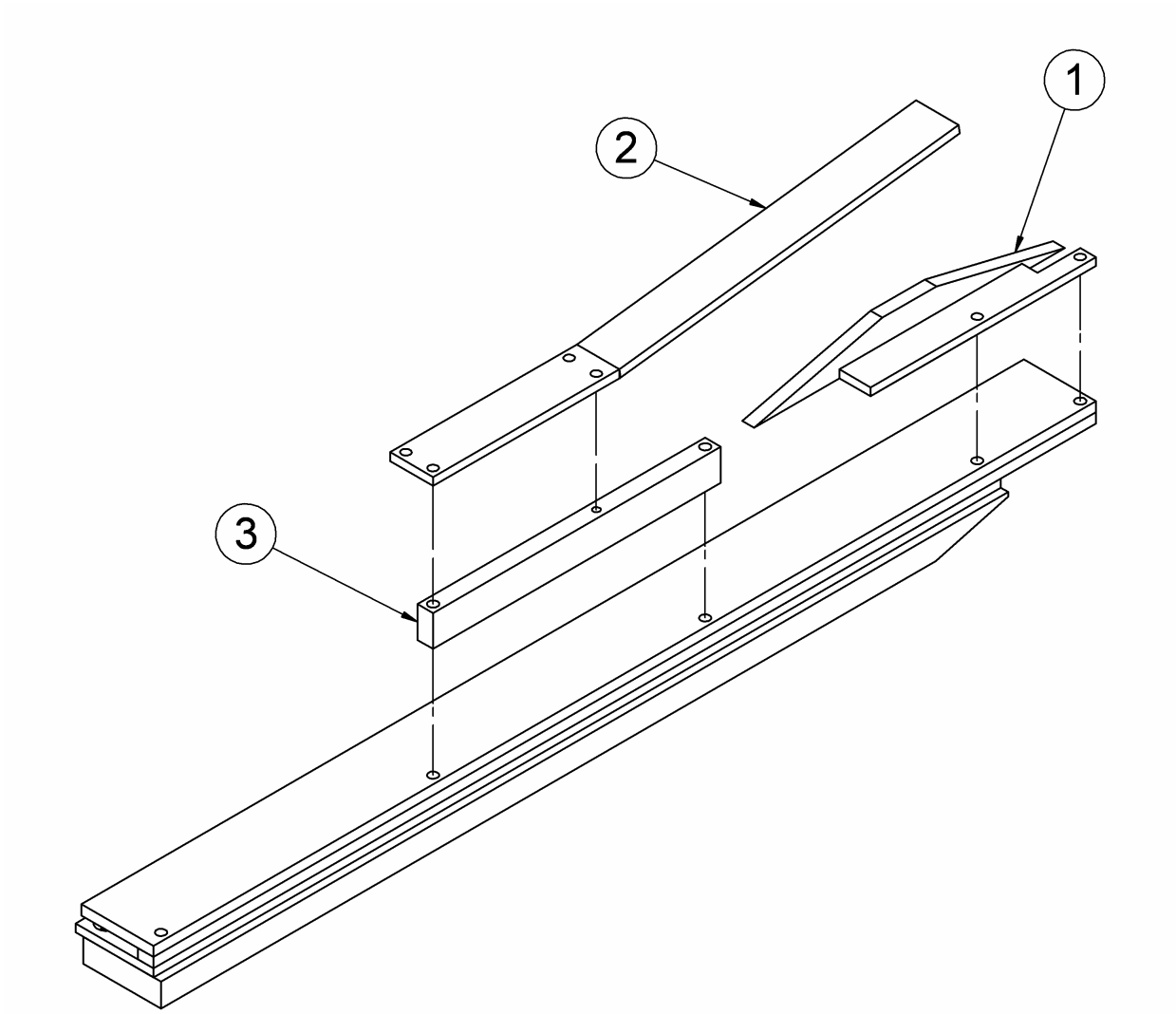
Cam Operating Components For Pusher Attachment

Item	Qty.	Part No.	Description
1	1R / 1L	00-03456-00	CAM, TRAY FLAP PUSHER BAR
2	1	00-03601-00	CAM, PUSHER ARM RETURN
3	1	00-03602-00	SPACER, PUSHER ARM RETURN CAM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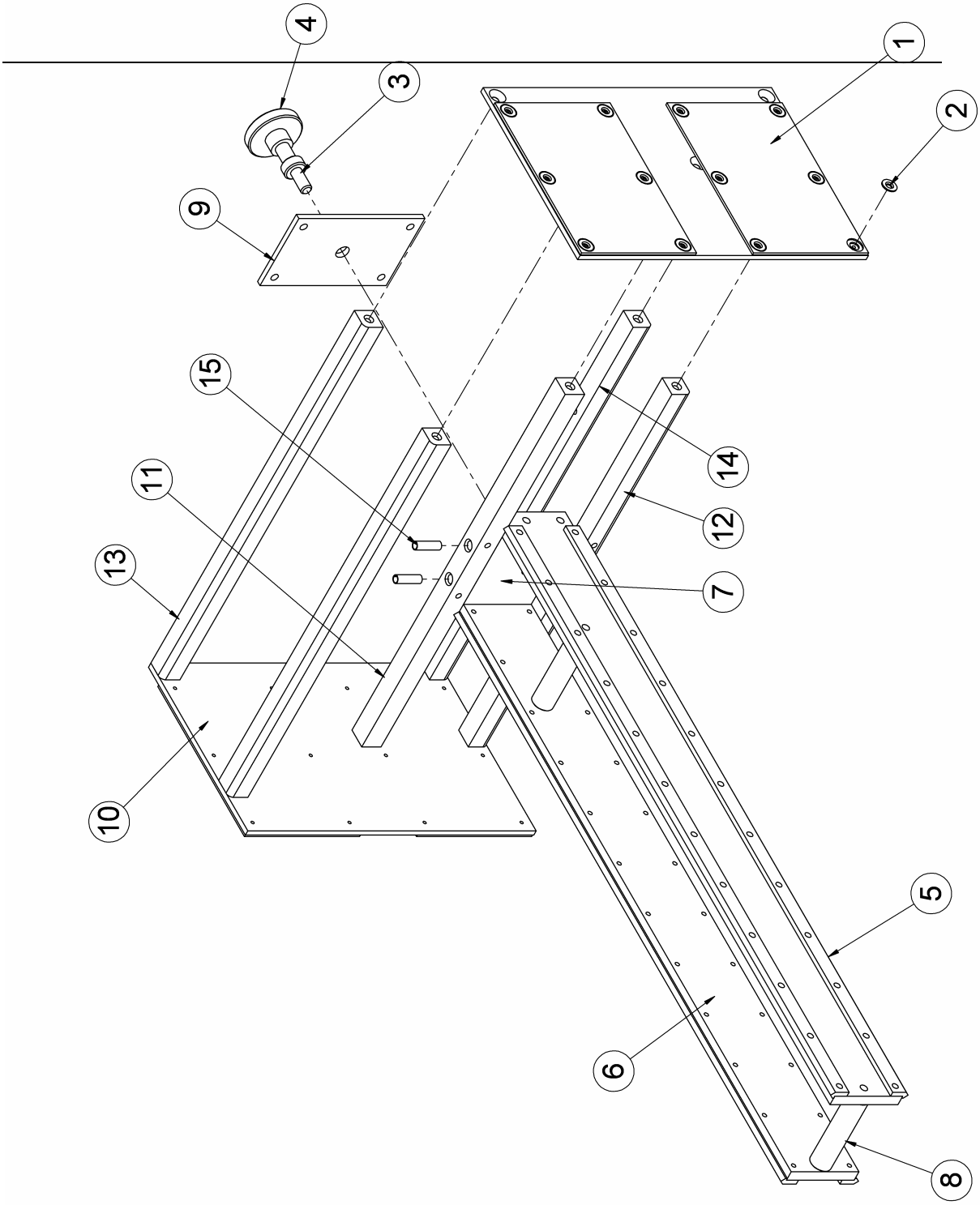
Linear Mandrel Assembly

Item	Qty.	Part No.	Description
1	4	00-03311-xx	MANDREL, TEFLON COVER
2	24	00-03463-00	MANDREL, TEFLON WASHER
3	2	00-04852-01	STUD, MANDREL MOUNTING
4	1	00-04852-02	KNOB, MANDREL MOUNTING STUD
5	4	00-08908-00	V-TRACK
6	1R/1L	00-08909-00	MOUNT BAR, V-TRACK
7	1	00-08910-00	CLAMP PLATE, MANDREL CARRIAGE
8	2	00-08919-00	SHAFT, CON ROD PIVOT
9	1	00-07591-00	PLATE, MANDREL MOUNT
10	1R/1L	00-07592-00	MANDREL SIDE PLATE
11	1	00-07590-00	MANDREL SPREADER BAR
12	1	00-07589-00	MANDREL SPREADER BAR
13	2	00-07588-00	MANDREL SPREADER, TOP
14	1	00-07588-01	MANDREL SPREADER, LOWER FRONT
15	2	07-00006-00	PIN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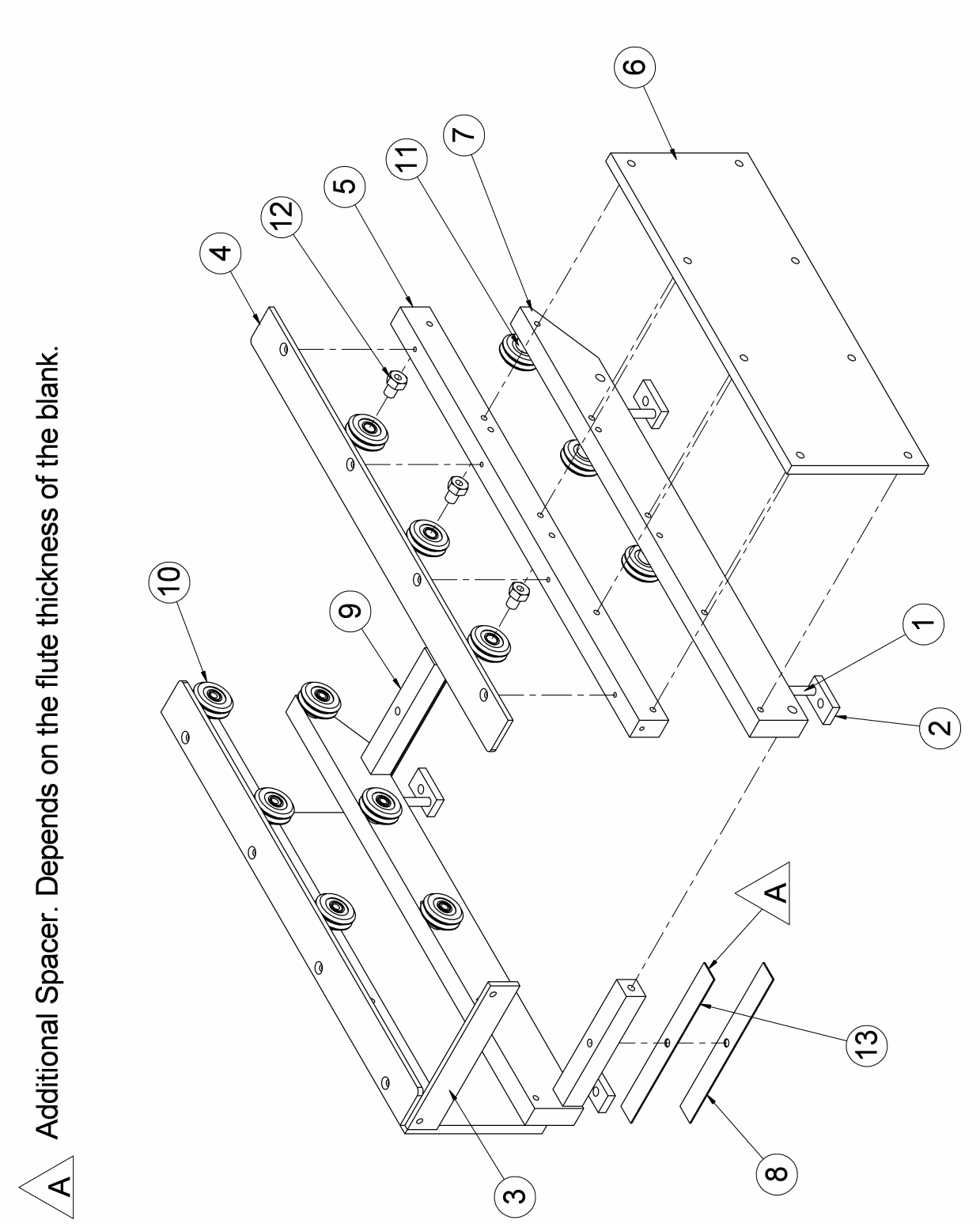
Linear Mandrel Base Assembly

Item	Qty.	Part No.	Description
1	8	00-02942-04	STUD, CLAMP SUPPORT
2	4	00-03030-00	PLATE, CLAMP
3	1	00-08911-00	TIE BAR, UPPER BASE MOUNT
4	2	00-08912-00	GUARD, UPPER V-WHEEL MOUNT
5	2	00-08913-00	BAR, UPPER V-WHEEL MOUNT
6	2	00-08914-00	PLATE, UPPER V-WHEEL MOUNT
7	2	00-08915-00	LOWER MOUNT BAR, V-WHEEL MANDREL CARRIAGE
8	2	00-08916-00	SHIM, MANDREL SPACER
9	2	00-08917-00	SPACER, V-WHEEL MOUNT BAR – MANDREL CARRIAGE
10	12	05-00087-00	V-WHEEL
11	6	05-00088-00	STATIONARY BUSHING
12	6	05-00089-00	ADJUSTABLE BUSHING
13		NOT USED	SPACER


A Additional Spacer. Depends on the flute thickness of the blank.
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Master Parts List

Qty.	Stock No.	Part No.	Description
1	00-02411-02	G2411B	FRAME, LOWER ASS'Y (42 1/2 ID)
	00-02411-03	G2411C	FRAME, LOWER ASS'Y (54 1/2 ID)
1	00-02430 -03	G2430C	SPREADER, TRANSMISSION PLATE (1T4)
	00-02430 -05	G2430E	SPREADER, TRANSMISSION PLATE (1T6)
1	00-02443-02	G2443-B	SHAFT, TRANSMISSION PINION (1T4)
	00-02443-03	G2443-C	SHAFT, TRANSMISSION PINION (1T6)
2	00-02444-00	G2444	RING, BEARING CLAMP
1	00-02447-00	G2447	RING, MAIN SHAFT BEARING CLAMP
1	00-02456-00	G2456	GEAR PINION, TRANSMISSION
1	00-02508-02	G2508B	SHAFT, TRANSMISSION GEAR (1T4)
	00-02508-03	G2508C	SHAFT, TRANSMISSION GEAR (1T6)
1	00-02619-01	G2619A	GEAR, TRANSMISSION MAIN
1	00-02680-00	G2680	ROD, FORM PLUNGER CONNECTING
1	00-02706-03	G2706-C	GUARD, FEED POST (1T4) (ST. TRAY)
	00-02706-04	G2706-D	GUARD, FEED POST (1T6) (WIDE BASE TRAY)
1	00-02754-04	G2754D	COVER,MATT FEED FRAME UPRIGHT
1	00-02772-01R	G2772AR	FRAME, ASSEMBLY MATT FEED
1	00-02772-01L	G2772AL	FRAME, ASSEMBLY MATT FEED
1	00-02773-01	G2773A	COVER, MATT FEED SYSTEM (LH)
1	00-02775-01	G2775A	BAR, MATT FEED FRAME SPREADER (STD)
	00-02775-02	G2775B	BAR, MATT FEED FRAME SPREADER (WIDE BASE)
2	00-02785-01R	G2785AR	SHOE, TRAY FORMING
2	00-02785-01L	G2785AL	SHOE, TRAY FORMING
2	00-02831-01	G2831A	PAWL, MATT PICK
1	00-02832-05	G2832E	SHAFT, MATT FEED ROLLER (STANDARD)
	00-02832-06	G2832F	SHAFT, MATT FEED ROLLER (WIDE BASE)
4	00-02833-00	G2833	CLIP, TRANSMISSION COVER SUPPORT
1	00-02855-02	G2855B	CAM, BLANK PICK OPERATING
2	00-02876-03	G2876C	PLATE, PICK SHAFT BEARING
1	00-02877-02	G2877B	LEVER, BLANK PICK OPERATING
4	00-02879-01	G2879A	PAWL, TRAY STRIPPER
2	00-02880-00	G2880	COVER, LOWER TRANSMISSION
1	00-02891-01	G2891A	CON-ROD, BLANK PICK UPPER SECTION
1	00-02893-02	G2893B	CON-ROD, BLANK PICK LOWER SECTION
1	00-02895-05	G2895E	SHAFT, BLANK PICK (STANDARD)
	00-02895-06	G2895F	SHAFT, BLANK PICK (WIDE BASE)
1	00-02900-06L	G2900FL	PLATE, FEED WHEEL SHAFT MOUNTING (1T4)
	00-02900-07L	G2900GL	PLATE, FEED WHEEL SHAFT MOUNTING (1T6)
1	00-02900-06R	G2900FR	PLATE, FEED WHEEL SHAFT MOUNTING (1T4)

Qty.	Stock No.	Part No.	Description
2	00-02905-01	G2905A	BAR, BLANK GUIDE VERTICAL SUPPORT
1	00-02906-01	G2906A	WHEEL., BLANK FEED (9 INCH)
	00-02906-02	G2906B	WHEEL., BLANK FEED (10 INCH)
2	00-02913-02	G2913B	SUPPORT TRAY BLANK
6	00-02917-00	G2917	NEEDLE, BLANK PICK
4	00-02918-00	G2918	GIB, TRAY, BLANK SUPPORT
1	00-02925-00	G2925	PAWL, BACK UP
2	00-02927-02R	G2927BR	PLOW, INNER FLAP FORMING
2	00-02927-02L	G2927BL	PLOW, INNER FLANGE FORMING
2	00-02929-02L	G2929BL	BAR, TRAY BLADE SUPPORT
4	00-02933-03	G2933C	SHOE, OUTSIDE FLAP FORMING
2	00-02934-00	G2934	PLATE, HOPPER GATE MOUNTING
2	00-02935-01	G2935A	BAR, BLANK HOPPER GATE MOUNTING
2	00-02937-05R	G2937ER	BLADE, BLANK SIUPPORT
2	00-02937-05L	G2937EL	BLADE, BLANK SIUPPORT
4	00-02942-04	G2942D	STUD, CLAMP SUPPORT TRAYS
1	00-02999-04	G2999D	BAR, IDLE ROLLER MOUNT (STANDARD)
	00-02999-05	G2999E	BAR, IDLE ROLLER MOUNT (WIDE BASE)
4	00-03018-00	G3018	PLATE, TRANSMISSION COVER LATCH
4	00-03024-01	G3024A	SPACER, TRAYFORMER BASE (3/16” THICK)
8	00-03028-02	G3028B	SEGMENTS, GLUE PROGRAM
1	00-03029-00	G3029	DISC,INTERMITTENT GLUE PROGRAM
	00-03029-01	G3029A	DISC,INTERMITTENT GLUE PROGRAM
4	00-03030-00	G3030	PLATE, CLAMP
2	00-03031-00	G3031	PLATE, CLAMP
2	00-03032-01	G3032A	SPACER, GUIDE CAP
1	00-03047-02	G3047B	SPACER VERTICAL GUIDE
2	00-03048-02	G3048B	SUPPORT VERTICAL GUIDE
1	00-03050-00	G3050	BRACKET, BACK UP PAWL
2	00-03054-01	G3054A	SHOE, CENTER FLANGE FORMING
1	00-03064-01L	G3064AL	BAR, MELT POT CLAMP
1	00-03064-01R	G3064AR	BAR, MELT POT CLAMP
2	00-03081-00	G3081	ROD END PICK TENSION
2	00-03082-00	G3082	EYE, PICK TENSION SPRING BOLT
2	00-03126-00	G3126	SPACER, FEED POST GUIDE
2	00-03151-04	G3151D	SPACER, GLUE PUMP HOUSING
1	00-03179-01	G3179A	STOP, PICK CAM FOLLOWER ARM
1	00-03197-00	G3197	WASHER, MAIN DRIVE GEAR RETAINING
5	00-03198-00R	G3198R	DEFLECTOR BLANK GUIDE
5	00-03198-00L	G3198L	DEFLECTOR BLANK GUIDE
2	00-03204-00	G3204	BRACE, FEED FRAME IDLE

Qty.	Stock No.	Part No.	Description
1	00-03218-00	G3218	PULLEY 17", JACK SHAFT (12-35 TRAYS PER MINUTE)
1	00-03230-00	G3230	BELT, MOTOR DRIVE
1	00-03231-00	G3231	PULLEY, VARI DRIVE MOTOR
1	00-03237-02	G3237B	SOLENOID, MAG. BRAKE RELEASE (120 VOLT RATED)
1	00-03238-00	G3238	BRACKET, BRAKE SOLENOID MOUNTING
1	00-03239-00	G3239	LEVER, MAG. BRAKE OPERATING
1	00-03240-01	G3240A	SCREW, BRAKE LEVER PIVOT
2	00-03241-00	G3241	WASHER, BRAKE PRESSURE SPRING
1	00-03242-00	G3242	BRAKE SHOE AND LINING
2	00-03243-01	G3243A	STUD, BRAKE SHOE RETAINING
1	00-03244-00	G3244	BOX, BRAKE AND SOLENOID COVER
1	00-03244-01	G3244A	PLATE, SOLENOID COVER MOUNTING
1	00-03245-01	G3245A	CAM, CYCLE MICRO LIMIT SWITCH
4	00-03290-00	G3290	BRACKET, FORMING SHOE MOUNTING SIDE BAR
2	00-03291-00	G3291	PLATE, UPPER TRAY FORMING SHOE MNT. CLAMP
2	00-03291-01	G3291A	PLATE, UPPER TRAY FORMING SHOE MNT. FIXED
1	00-03292-00	G3292	BAR, UPPER TRAY FORMING SHOE MOUNT (1T4)
1	00-03292-01	G3292A	BAR, UPPER TRAY FORMING SHOE MOUNT (1T6)
2	00-03293-01	G3293A	BAR, FORMING SHOE MOUNTING SIDE
2	00-03450-00	G3450	ARM, SHAFT PICK PAWL
2	00-03465-01	G3465A	STOP, TRAY BOTTOM
2	00-03477-00	G3477	STUD, GLUE PUMP SUPPORT
4	00-03514-04	G3514D	COMPRESSION PLATE, EXTENDED TRAY
1	00-03536-02	G3536B	GUARD, FEED WHEEL STD.
8	00-03537-02	G3537B	BRACKET, BACK GUARD HINGE
1	00-03540-00	G3540	BAR, POWER PANEL BOTTOM MOUNTING
1	00-03541-00	G3541	BAR, POWER PANEL TOP MOUNTING
4	00-03566-00	G3566	BAR, SHOE TRAY FORMING CLAMP
2	00-04825-01	G4825A	BLOCK, MATT PICK STRAP MOUNTING
1	00-04826-00	G4826	STRAP, BLANK PICK LEVER MTG.
1	00-04834-00	G4834	SPROCKET, FEED WHEEL SHAFT DRIVE, 40B24
1	00-04839-00	G4839	MANDREL CRANK SHAFT ARM WELDMENT 1T4
	00-04861-00	G4861	MANDREL CRANK SHAFT ARM WELDMENT 1T6
1	00-04899-00	G4899	MANDREL, FEED POST (BOLTED TYPE)
1	00-07299-00	G7299	SPROCKET, FEED DRIVE (JACK SHAFT)40 B 10
2	00-08624-00	G8624	PLATE, INTERLOCK MOUNTING (REAR GUARD)
2	00-08625-00	G8625	PLATE, INTERLOCK FRONT
1	01-00010-00	GA10	SET COLLAR ROD END STOP
2	01-00017-00	GA17	SET COLLAR GLUE DISC LOCATING
1	02-00267-00	GB267	BUSHING 13/16 OD x 21/64 ID
1	02-00271-00	GB271	BUSHING 1/2 OD x 21/64 ID

Qty.	Stock No.	Part No.	Description
4	02-00311-00	GB311	BUSHING 3/8 OD x 1/4 ID x 49
1	02-00379-00	GB379	BUSHING 1 1/8 OD x 3/4 ID
2	02-00387-00	GB387	BUSHING 1/2 OD x 13/64 ID
1	04-00021-00	GD21	MICRO LIMIT SWITCH
1	04-00050-00	GD50	SINGLE FLASH STROBE LIGHT
2	04-00065-01	GD65A	INTERLOCK SAFETY SWITCH
1	04-00069-00	GD69	VARIABLE SPEED AC MOTOR CONTROLLER IDM 230V.-AC-3PH
1	04-00069-01	GD69A	VARIABLE SPEED AC MOTOR CONTROLLER IDM 460V.-AC-3PH
1	04-00069-02	GD69B	VARIABLE SPEED AC MOTOR CONTROLLER IDM 230V.-AC-1PH
1	04-00070-00	GD70	2 WATT POTENTIOMETER W/ ADJ. KNOB
1	04-00071-00	GD71	CIRCUIT BREAKER 3 POLE 240 V. AC 30 AMP SQ."D" FAL34030
1	04-00071-01	GD71A	CIRCUIT BREAKER 3 POLE 480 V. AC 15 AMP.SQ."D" FAL34015
1	05-00002-00	GE2	BEARING NDH 488507 OR EQUAL
1	05-00003-00	GE3	BEARING NDH 88507 0R EQUAL
2	05-00013-00	GE13	BEARING, FEED POST AND PINION SHAFT (L.H END)
2	05-00013-01	GE13A	BEARING, FEED POST AND PINION SHAFT (RH END)
1	05-00043-03	GE43C	CAM FOLLOWER ROLLER, FORM PLUNGER FEED POST
1	05-00051-01	GE51A	BEARING, PICK SHAFT OPERATING
4	05-00065-01	GE65A	BEARING, ROBERTS 1"--2 HOLE HANGER UNIT
2	05-00070-00	GE70	BEARING, BLANK PICK SHAFT
2	05-00070-01	GE70A	BEARING, BLANK PICK SHAFT
4	07-00004-02	GG4B	PIN, BLANK PICK PAWL PIVOT
1	08-20001-11	GHB1K	CHAIN, FEED ROLL DRIVE
1	10-00009-01	GJ9A	KEY, FEED ROLL DRIVE SPROCKET
1	10-00009-02	GJ9B	KEY, FEED ROLL DRIVE SPROCKET
1	10-00009-03	GJ9C	KEY, BLANK PICK OPERATING LEVER
1	10-00009-04	GJ9D	KEY, TRANSMISSION PINION GEAR
1	10-00009-04	GJ9D	KEY, MOTOR DRIVE SHAFT
1	10-00009-04	GJ9D	KEY, VARI-DRIVE PULLEY
1	10-00012-01	GJ12A	KEY, TRANSMISSION MAIN GEAR
1	13-00004-04	GM4D	MOTOR, 3/4 HP 1140 RPM BALDOR
1	13-00005-05	GM5D	MOTOR, 1 HP 1140 RPM BALDOR
1	19-00017-00	GS17	SPRING, BRAKE PRESSURE
2	19-00042-00	GS42	SPRING, BLANK PICK PAWL
2	19-00054-00	GS54	SPRING, UPPER FORMING SHOE MTG. BAR CLAMP PLATE
4	19-00086-00	GS86	SPRING, FRAME COVER LATCH BAR
1	19-00159-00	GS159	SPRING, BLANK PICK RETURN

Qty.	Stock No.	Part No.	Description
4	19-00086-00	GS86	SPRING, FRAME COVER LATCH BAR
1	19-00159-00	GS159	SPRING, BLANK PICK RETURN
5	23-00001-00	GW1	WASHER, 1” OD x 29/64” ID x 5/32” THICK
2	23-00001-01	GW1A	WASHER, 1” OD x 25/64” ID x 5/32” THICK
6	23-00001-02	GW1B	WASHER 1” OD x 5/16” D x 5/32 THICK
7	23-00012-00	GW12	WASHER 1/4” OD x 25/64 ID x 3/16 THICK
7	23-00056-00	GW56	WASHER 3/4” OD x 21/64 ID x 1/8 THICK
2	23-00062-00	GW62	WASHER 1 5/8” OD x 5/16 ID x 3/16 THICK
2	23-00065-00	GW65	WASHER 1” OD x 21/64 ID x /8 THICK
1	60-00160-03L		MANDREL GUIDE RAIL TRAY
1	60-00160-03R		MANDREL GUIDE RAIL TRAY
1	60-00168-00		FEED SAFETY ARM ASSEMBLY
1	60-00169-01L		MANDREL GUIDE RAIL TRAY
1	60-00169-01R		MANDREL GUIDE RAIL TRAY
1	60-00171-01		IDLER TAKE UP SPROCKET
2	60-00175-02		BOTTOM STOP
1	60-00178-00		REBOUND STOP
1	60-00179-00		IDLE FEED ROLL ASSEMBLY
1	60-00199-01L		MELT POT AND THERMOSTAT ASSEMBLY
1	60-00199-01R		MELT POT AND THERMOSTAT ASSEMBLY
1	60-00269-00		ELECTRICAL BOX STANDARD

Electrical Parts List

QTY	PART NO.	MANUF.	MFG. PART NO.	DESCRIPTION
1	04-00029-01	ALLEN-BRADLEY	800T-FXQ10RA1	2-POSITION PUSH-PULL 120VAC ILLUMINATED PUSH-BUTTON, RED, 1 N.O., 1 N.C.
1	INCL.	ALLEN-BRADLEY	800T-X504	PUSH BUTTON STANDARD LEGEND - "EMERGENCY STOP"
1	04-00028-05	ALLEN-BRADLEY	800T-J91A	3-POSITION SELECTOR SWITCH, STANDARD KNOB, SPRING CENTERED, 1 N.O., 1 N.C.
1	INCL.	ALLEN-BRADLEY	800T-X507	PUSH BUTTON STANDARD LEGEND - "FOR.-OFF-REV."
1	04-00027-04	ALLEN-BRADLEY	800T-A1B	PUSH BUTTON, GREEN, FLUSH, MOMENTARY, 2 N.O., 2 N.C.
1	INCL.	ALLEN-BRADLEY	800T-X547	PUSH BUTTON STANDARD LEGEND - "START"
1	04-00028-00	ALLEN-BRADLEY	800T-H2D1	2-POSITION SELECTOR SWITCH, STANDARD KNOB, 1 N.O.
1	INCL.	ALLEN-BRADLEY	800T-X559E	PUSH BUTTON STANDARD LEGEND W/CUSTOM TEXT "VACUUM OFF-ON"
1	04-00028-04	ALLEN-BRADLEY	800T-H2B	2-POSITION SELECTOR SWITCH, STANDARD KNOB, 2 N.O., 2 N.C.
1	INCL.	ALLEN-BRADLEY	800T-X547	PUSH BUTTON STANDARD LEGEND - "JOG-RUN"
1	04-00030-01	ALLEN-BRADLEY	800T-J2B	3 POSITION SELECTOR SWITCH, STANDARD KNOB, 2 N.O., 2 N.C.
1	INCL.	ALLEN-BRADLEY	800T-X511	PUSH BUTTON STANDARD LEGEND - "HAND-OFF-AUTO"
1	04-00031-00	ALLEN-BRADLEY	800T-XD5	PUSH BUTTON, MINI CONTACT BLOCK, 1 N.O.
1	04-00031-01	ALLEN-BRADLEY	800T-XD6	PUSH BUTTON, MINI CONTACT BLOCK, 1 N.C.
1	04-00031-02	ALLEN-BRADLEY	800T-XA	PUSH BUTTON, SHALLOW CONTACT BLOCK, 1 N.O., 1 N.C.
1	04-00023-01	ALLEN-BRADLEY	194R-NN030P3	NON-FUSED DISCONNECT SWITCH, 30 AMP
1	INCL.	ALLEN-BRADLEY	194R-HS4E	DISCONNECT SWITCH OPERATING HANDLE, RED/YELLOW, W/DEFEATER, IP66, NEMA 4X
1	INCL.	ALLEN-BRADLEY	194R-R1	DISCONNECT SWITCH OPERATING SHAFT, STANDARD LENGTH
1	04-00023-02	ALLEN-BRADLEY	194R-NN060P3	NON-FUSED DISCONNECT SWITCH, 60 AMP
1	INCL.	ALLEN-BRADLEY	194R-HS4E	DISCONNECT SWITCH OPERATING HANDLE, RED/YELLOW, W/DEFEATER, IP66, NEMA 4X
1	INCL.	ALLEN-BRADLEY	194R-R1	DISCONNECT SWITCH OPERATING SHAFT, STANDARD LENGTH
1	04-00043-04	ALLEN-BRADLEY	700-HA33A1	TYPE HA TUBE BASE RELAY WITH PIN TERMINALS, 3-POLE, 120VAC
1	22-00010-03	ALLEN-BRADLEY	700-HN101	TYPE HN RELAY SOCKET, 11-PIN, FOR 3PDT TYPE HA RELAY
4	04-00043-00	ALLEN-BRADLEY	700-HA32A1	TYPE HA TUBE BASE RELAY WITH PIN

QTY	PART NO.	MANUF.	MFG. PART NO.	DESCRIPTION
				TERMINALS, DPDT, 2-POLE, 120VAC
4	22-00010-02	ALLEN-BRADLEY	700-HN100	TYPE HN RELAY SOCKET, 8-PIN, FOR 2PDT TYPE HA RELAY
1	ADD	ALLEN-BRADLEY	700-HN100	TYPE HN RELAY SOCKET, 8-PIN, FOR 2PDT TYPE HA RELAY
1	22-00013-06	ALLEN-BRADLEY	1492-FB3C30-L	FUSE HOLDER, 3-POLE, 30 AMP, 600 V, BLOWN FUSE INDICATOR
2	OR	ALLEN-BRADLEY	1492-FB3C30-L	FUSE HOLDER, 3-POLE, 30 AMP, 600 V, BLOWN FUSE INDICATOR
2	22-00013-10	ALLEN-BRADLEY	1492-FB2C30-L	FUSE HOLDER, 2-POLE, 30 AMP, 600 V, BLOWN FUSE INDICATOR
2	OR	ALLEN-BRADLEY	1492-FB2C30-L	FUSE HOLDER, 2-POLE, 30 AMP, 600 V, BLOWN FUSE INDICATOR
1	ADD	ALLEN-BRADLEY	1492-FB2C30-L	FUSE HOLDER, 2-POLE, 30 AMP, 600 V, BLOWN FUSE INDICATOR
2	ADD	ALLEN-BRADLEY	1492-FB2C30-L	FUSE HOLDER, 2-POLE, 30 AMP, 600 V, BLOWN FUSE INDICATOR
1	04-00072-00	ALLEN-BRADLEY	100-C09D10	CONTACTOR, 120V, 3 POLE, 9AMP, IEC
1	04-00073-00	ALLEN-BRADLEY	193-EA4CB	OVERLOAD RELAY, IEC, 0.32 - 1.0 AMP, 380V - 5/8 HP, 460V - 5/8 HP
1	04-00073-01	ALLEN-BRADLEY	193-EA4DB	OVERLOAD RELAY, IEC, 1.0 - 2.9 AMP, 230V - 5/8 HP, 380V - 3/4 HP, 460V - 3/4 HP
1	04-00073-02	ALLEN-BRADLEY	193-EA4EB	OVERLOAD RELAY, IEC, 1.6 - 5.0 AMP, 230V - 3/4 HP
1	22-00032-00	ALLEN-BRADLEY	1492-PDM3141	POWER BLOCK, 3 POLE, 1-4 TERMS
7	22-00027-02	ALLEN-BRADLEY	1492-EA35	TERMINAL BLOCK END ANCHOR
3	04-00075-01	BUSSMANN	LP-CC-5 6/10	FUSE, TIME DELAY, CURRENT LIMITING, 5.6 AMP
3	04-00075-00	BUSSMANN	LP-CC-3	FUSE, TIME DELAY, CURRENT LIMITING, 3 AMP
2	04-00075-03	BUSSMANN	LP-CC-20	FUSE, TIME DELAY, CURRENT LIMITING, 20 AMP
3	04-00075-02	BUSSMANN	LP-CC-12	FUSE, TIME DELAY, CURRENT LIMITING, 12 AMP
2	04-00076-01	BUSSMANN	FNQ-R-3	FUSE, TIME DELAY, 3 AMP
2	04-00076-00	BUSSMANN	FNQ-R-2	FUSE, TIME DELAY, 2 AMP
1	04-00078-00	BUSSMANN	MDA-5	FUSE, TIME DELAY, CERAMIC TUBE, 5 AMP
2	04-00077-00	BUSSMANN	KTK-R-10	FUSE, FAST ACTING, 10 AMP
4	OR	BUSSMANN	KTK-R-10	FUSE, FAST ACTING, 10 AMP
2	04-00076-02	BUSSMANN	FNQ-R-15	FUSE, TIME DELAY, 15 AMP
1	00-02791-11	B-LINE		MAIN ELECTRICAL ENCLOSURE
1	INCL.	B-LINE		MAIN ENCLOSURE PANEL
1	04-00070-00	DIGI-KEY	RV4N252C-ND	POTENTIOMETER, 2.5KOHM, 2WATT (PRECISION ELECTRONIC COMPONENTS LTD.)
1	INCL.	DIGI-KEY	226-1007-ND	POTENTIOMETER CONTROL KNOB (KILO INTERNATIONAL)
1	04-00018-01	IDEC	RTE-P11-120VAC	TIME DELAY RELAY, DELAY ON, 0.1 TO 60 SECS., 120VAC, 8-PIN TUBE BASE
36"	22-00027-03	GRAINGER	6X295	IEC 35MM DIN MOUNTING RAIL,

QTY	PART NO.	MANUF.	MFG. PART NO.	DESCRIPTION
				ALUMINUM, 36" LENGTH
1	22-00016-12	JEFFERSON	636-1191-000	CONTROL TRANSFORMER, 500VA, 480/240-120V
1	22-00029-01	NEWARK	13F141R50.0	POWER RESISTOR, 50 WATT, 50 OHM
7'	22-00028-01	PANDUIT	C1LG6	WIRE DUCT COVER, PANDUIT 1"W
7'	22-00028-02	PANDUIT	F1X2LG6	WIRE DUCT, 1"W X 2"H X 6 FT
46	22-00031-00	WEIDMULLER	102010	IEC TERMINAL BLOCK, WDU4, TERMINALS
2	22-00031-01	WEIDMULLER	105000	IEC TERMINAL BLOCK, WDU4, END PLATE
5	22-00031-02	WEIDMULLER	105206	IEC TERMINAL BLOCK, WDU4, JUMPERS
1	22-00031-03	WEIDMULLER	101400	IEC TERMINAL BLOCK, WSI 6/2, FUSE HOLDER
1	04-00069-03	SQUARE D	ATV18U29M2U	ALTIVAR 18 ADJUSTABLE SPEED DRIVE, 230VAC, 2HP, SINGLE PHASE
1	04-00069-04	SQUARE D	ATV18U29N4U	ALTIVAR 18 ADJUSTABLE SPEED DRIVE, 460VAC, 2HP, THREE PHASE
1	04-00050-02	SQUARE D	XVA C331	LENS UNIT - STEADY LIGHT, GREEN
1	INCL.	SQUARE D	XVA C451	LENS UNIT - FLASHING LIGHT, ORANGE
1	INCL.	SQUARE D	XVA C211	COVER AND 5 CIRCUIT BASE
1	00-02791-11	B-LINE		MAIN ELECTRICAL ENCLOSURE
1	INCL.	B-LINE		MAIN ENCLOSURE PANEL
1	04-00070-00	DIGI-KEY	RV4N252C-ND	POTENTIOMETER, 2.5KOHM, 2WATT (PRECISION ELECTRONIC COMPONENTS LTD.)
1	INCL.	DIGI-KEY	226-1007-ND	POTENTIOMETER CONTROL KNOB (KILO INTERNATIONAL)
1	04-00018-01	IDEC	RTE-P11-120VAC	TIME DELAY RELAY, DELAY ON, 0.1 TO 60 SECS., 120VAC, 8-PIN TUBE BASE
36"	22-00027-03	GRAINGER	6X295	IEC 35MM DIN MOUNTING RAIL, ALUMINUM, 36" LENGTH
1	22-00016-12	JEFFERSON	636-1191-000	CONTROL TRANSFORMER, 500VA, 480/240-120V
1	22-00029-01	NEWARK	13F141R50.0	POWER RESISTOR, 50 WATT, 50 OHM
7'	22-00028-01	PANDUIT	C1LG6	WIRE DUCT COVER, PANDUIT 1"W
7'	22-00028-02	PANDUIT	F1X2LG6	WIRE DUCT, 1"W X 2"H X 6 FT
46	22-00031-00	WEIDMULLER	102010	IEC TERMINAL BLOCK, WDU4, TERMINALS
2	22-00031-01	WEIDMULLER	105000	IEC TERMINAL BLOCK, WDU4, END PLATE
5	22-00031-02	WEIDMULLER	105206	IEC TERMINAL BLOCK, WDU4, JUMPERS
1	22-00031-03	WEIDMULLER	101400	IEC TERMINAL BLOCK, WSI 6/2, FUSE HOLDER
1	04-00069-03	SQUARE D	ATV18U29M2U	ALTIVAR 18 ADJUSTABLE SPEED DRIVE, 230VAC, 2HP, SINGLE PHASE
1	04-00069-04	SQUARE D	ATV18U29N4U	ALTIVAR 18 ADJUSTABLE SPEED DRIVE, 460VAC, 2HP, THREE PHASE
1	04-00050-02	SQUARE D	XVA C331	LENS UNIT - STEADY LIGHT, GREEN
1	INCL.	SQUARE D	XVA C451	LENS UNIT - FLASHING LIGHT, ORANGE

QTY	PART NO.	MANUF.	MFG. PART NO.	DESCRIPTION
1	INCL.	SQUARE D	XVA C211	COVER AND 5 CIRCUIT BASE
1	INCL.	SQUARE D	XVA C00	1/2" NPT CONDUIT ADAPTER
2	INCL.	SQUARE D	DL1 BL120	LAMP - TYPE BA 15D, 120VAC, 7W
1	00-03540-01	SWF		BAR, ELECTRICAL PANEL BOTTOM MOUNTING
1	00-03541-01	SWF		BAR, ELECTRICAL PANEL TOP MOUNTING
1	00-08879-00	SWF		BRACKET, POTENTIOMETER MOUNTING

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